

FIG. 1

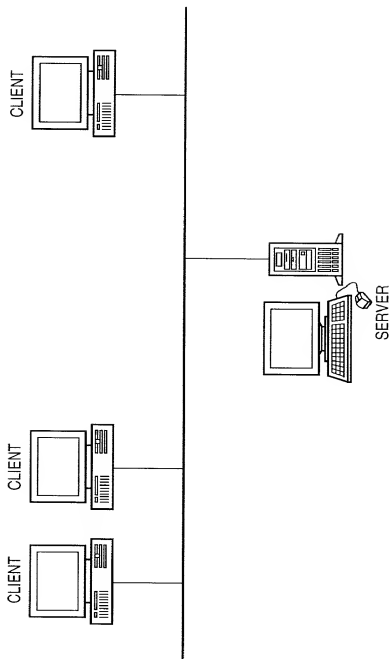


FIG. 2

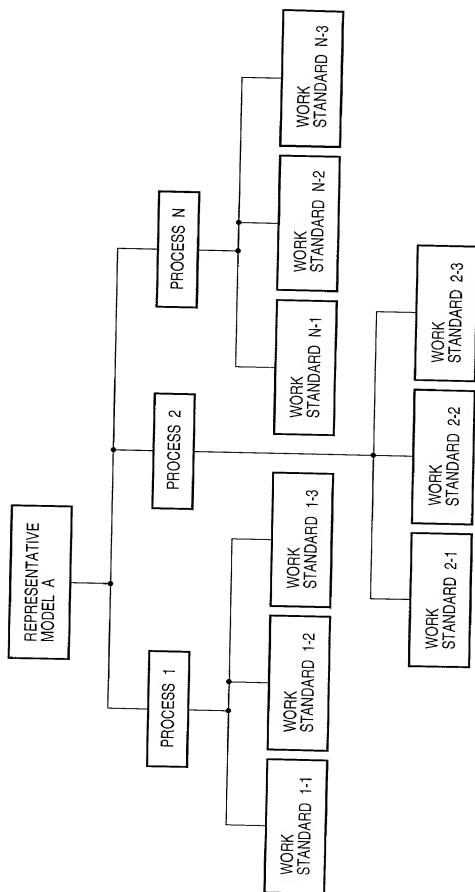


FIG. 4

STRUCTURE OF MASTER FILE

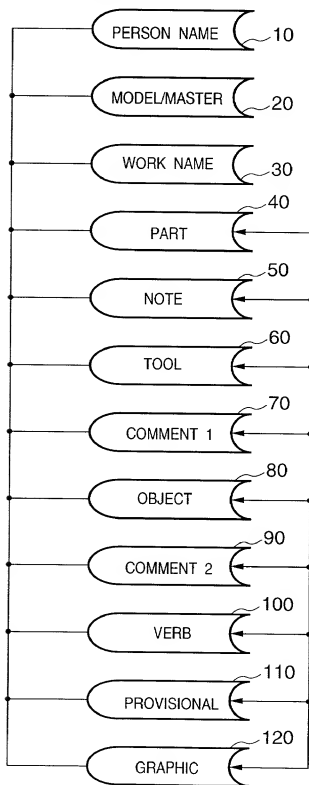


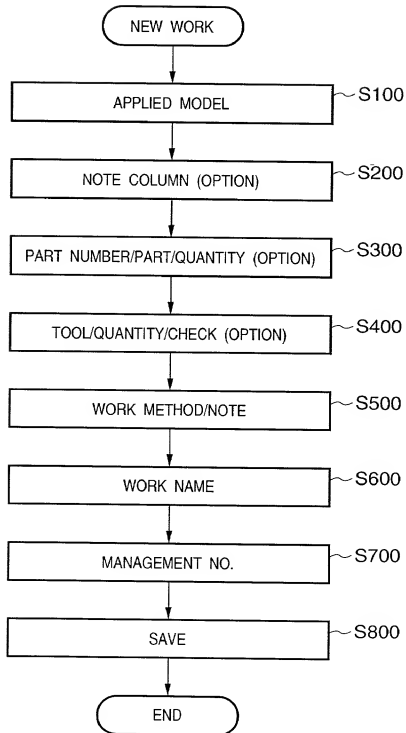
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX A250 II Q BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION				<input type="button" value="-"/> <input type="button" value="X"/>		
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J				
PART NUMBER		PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
						▲

302

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	-----
000 - 0000 - 002	PART 002		-----
000 - 0000 - 003	PART 003		-----
001 - 0000 - 001	PART 101	▼	-----
001 - 0000 - 002	PART 102		-----
111 - 1111 - 001	PART 001		-----
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

- WORK NAME

- CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

• WORK NAME

• CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※ 1105a

01 1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK CANCEL 1108

FIG. 12

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1201

1202

00 ※ 1105b

01

The diagram shows a form with a vertical border on the left and a wavy line on the right. The form contains several horizontal sections. The top section is labeled 'WORK STANDARD SYSTEM'. Below it are two sections for 'WORK NAME :' and 'WORK METHOD :'. These are followed by two large empty rectangular boxes. The first box is labeled '1201' and the second is labeled '1202'. Below these boxes are two more sections. The first of these contains '00 ※' and is labeled '1105b'. The second contains '01'.

FIG. 13

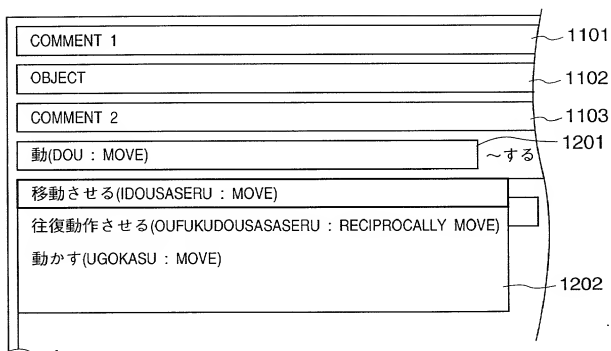


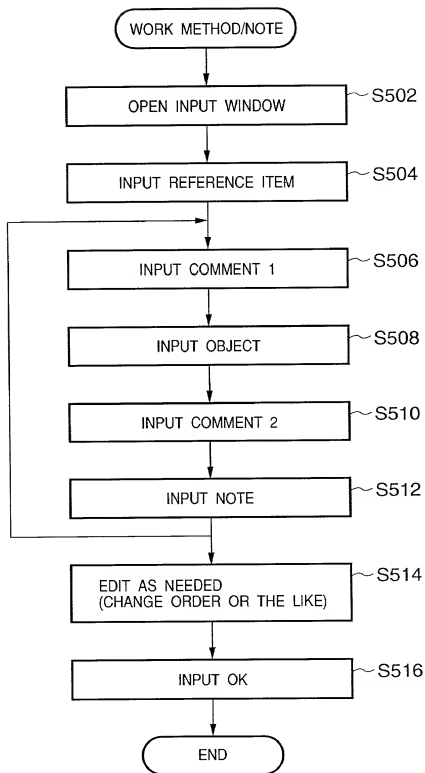
FIG. 14

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	1601
NOTE	
<p>SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu</p> <p>DONT PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE</p> <p>DONT HOOK PAPER GUIDE u ON SHEET HOLDER</p> <p>BEWARE OF IMITATIONS</p> <p>BEWARE OF IMITATIONS(Color Style Write</p>	
	1602

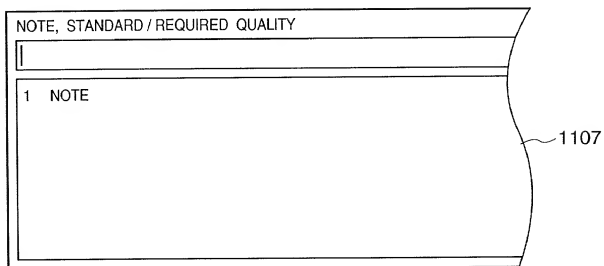
FIG. 17

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(T)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 19

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

The diagram shows a menu structure. On the left is a vertical list of items: "CONFIRM", "00 ※", "01 WIND AV CORD", "02 SET CRG HOLDER", "03", and "NOTE, STANDARD / REQUIRED QUALITY". To the right of the "03" item is a context menu (labeled 1802) containing the following options: "CUT(I)", "COPY(C)", "PASTE(P)", "ADD(A)", "DELETE(D)", "UNDO", "REVISE(CHANGE)", and "REVISE(DELETE)". The "PASTE(P)" option is highlighted with a thick border.

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	CUT(I) COPY(C) PASTE(P) ADD(A) DELETE(D) UNDO REVISE(CHANGE) REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

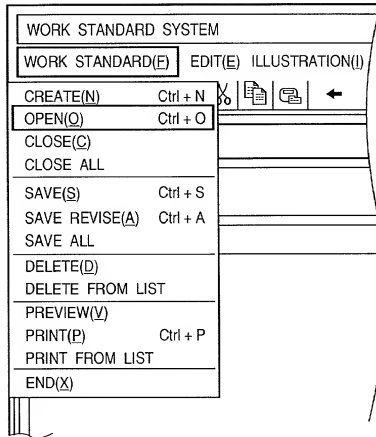
FIG. 22

FIG. 23

WORK STANDARD SYSTEM

☒ LATEST REVISION NUMBER

☐ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	ASFu取付	1997/09/13
SO-01-01(3)-E	01	ベース・トレード取付	1997/09/01
SO-01-03-E	01	ベース・トレード取付	1997/09/01
SO-01-04-E	01	ベース・トレード取付	1997/09/01
線処理			
SO-06-01-E	01	線処理	1997/09/01
SO-06-02-E	01	線処理	1997/09/01
SO-06-03-E	01	線処理	1997/09/01
SO-07-01(2)-E	01	レールグリッド塗布	1997/09/01
SO-08-01-E	01	レール取付	1997/09/01

OK

CANCEL

2301

FIG. 24





SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
		EDIT(E)	
01 CREATE		PowerPoint	
		✓ Canvas	

FIG. 25

WORK STANDARD 01 CREATION

302

APPLIED

PART NUMBER PART NAME

303

TOOL / TREATMENT DEVICE

No. WORK PROCEDURE

FILE NAME :

2501 2502 2503 2504

2500

CLEAR UPDATE CLOSE

REVISION NUMBER CONTENTS OF REVISION DATE PERSON IN CHARGE APPROVE

01 1997/09/25

WORK NAME

MANAGEMENT NO.

FIG. 26

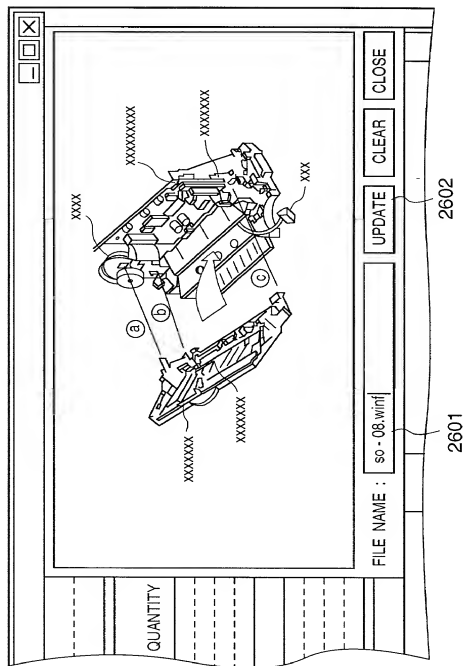


FIG. 27

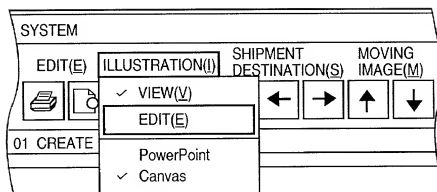


FIG. 28

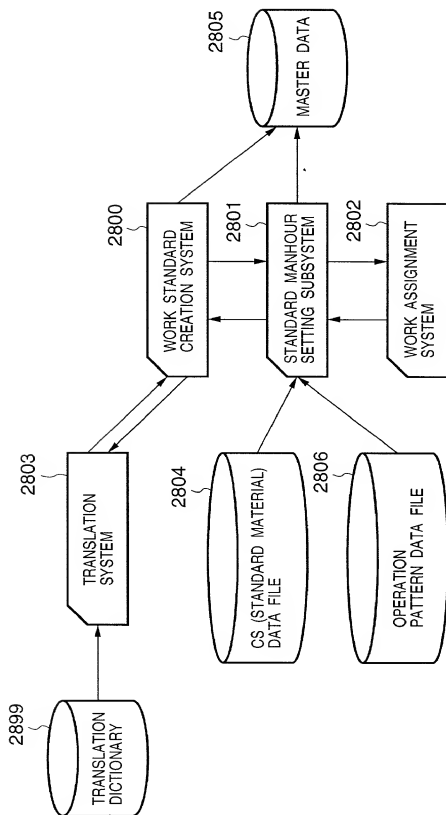


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

TRANSLATION OF WORK STANDARD

3001 3002 3003 3004 3000

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

DISPLAY DATA

ALL UNTRANSLATED UNCHECKED

DISPLAY LANGUAGE

JAPANESE ENGLISH

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4195

4196

4197

4198

4199

4200

4201

4202

4203

4204

4205

4206

4207

4208

4209

4210

4211

4212

4213

4214

4215

421

✕

WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)

WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT

[illegible]

FIG. 32

WORK PROCEDURE

X

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバーネをブレードレバーの ① 部に引っ掛ける

01 ブレードレバーネをブレードレバーの ① 部に引っ掛ける

02 ブレードレバーを矢印② 方向にスライドさせ引っ掛かり無くバネ力で戻ることを確認する

03 ブレードレバー軸先端がブレードホルダー先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Slide the blade lever in the direction of arrow ② and there is no catch and n...

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE

OK

CANCEL

3200

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<div> <div></div> <div></div> <div></div> </div>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S)	DOWN(W)
WORK STANDARD PN-030-020 01 New		PLAY(P)	X2056
		NEW(N)	A252 PLATEN UNIT
		DRIVE(D)	
Model	QG5-1317		

FIG. 34

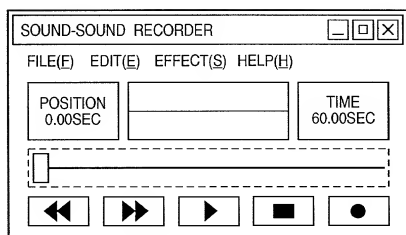


FIG. 36

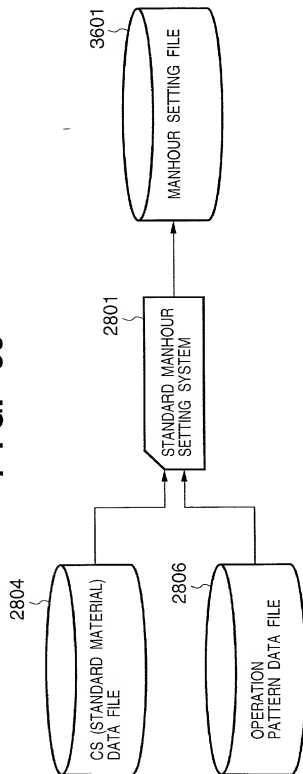


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

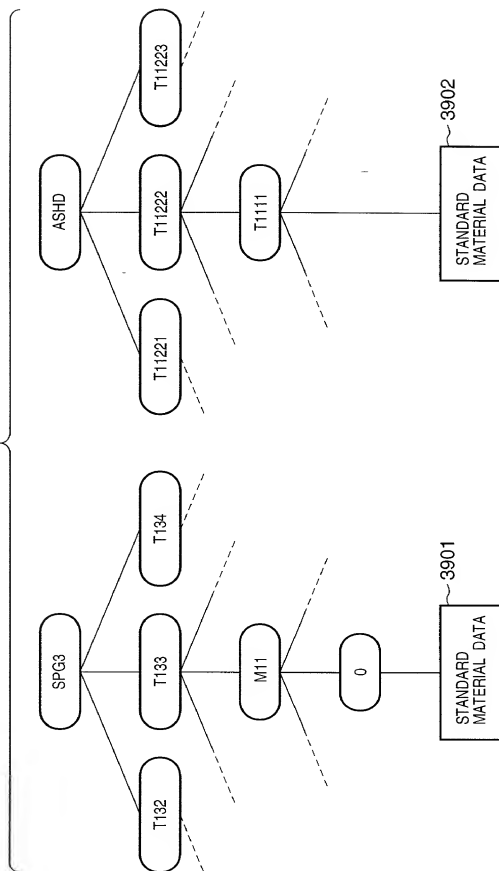
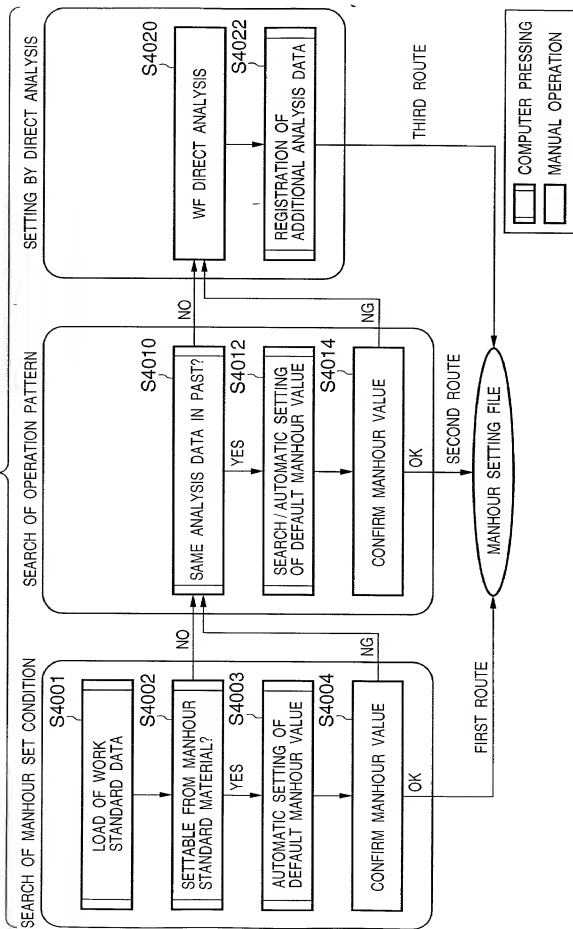


FIG. 40



[illegible]

DATA LOAD

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷 ^h を	負荷 ^h に取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷 ^h に取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

[illegible]

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD	MATERIAL	TIME VALUE
1	*	*ハネを	*に	組込む	SPG3	T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED	T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ	T2111 / T111111	16RU
4	*	*エリクを	*	組込む	RIN2	T11211 / SO	76RU
5	*	*コネタを	*	差し込む	CONN	T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6	M211 / 1	23RU

2804

43/143
FIG. 43

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	負荷ハネを負荷ハネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
3	分離ロー軸を負荷ハネ取付治具に取込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T11111
4	治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
5	分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGトアを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コトを		抜く	/GET:-50EGr2/M:-10E	16RU
7		測定用電源コトを		抜く	/GET:-50EGr2/M:-10E	16RU

2806

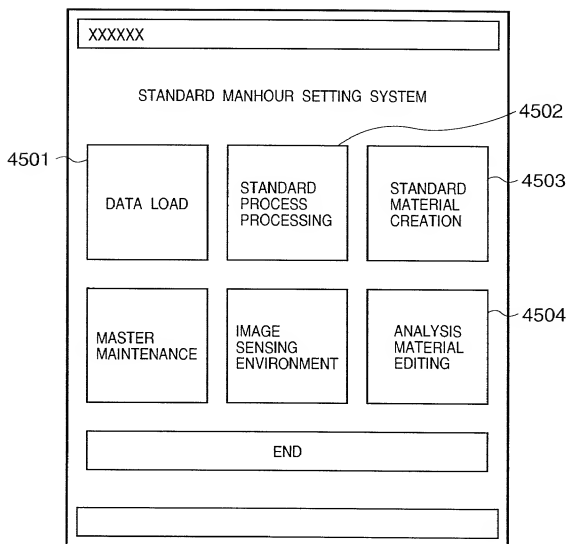
FIG. 45

FIG. 47

[illegible]

FIG. 48

4805 4804

LOAD OF DATA

4800

COMPONENT DESIGNATION

4801

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOOR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

4803

EXECUTE

CANCEL

4806

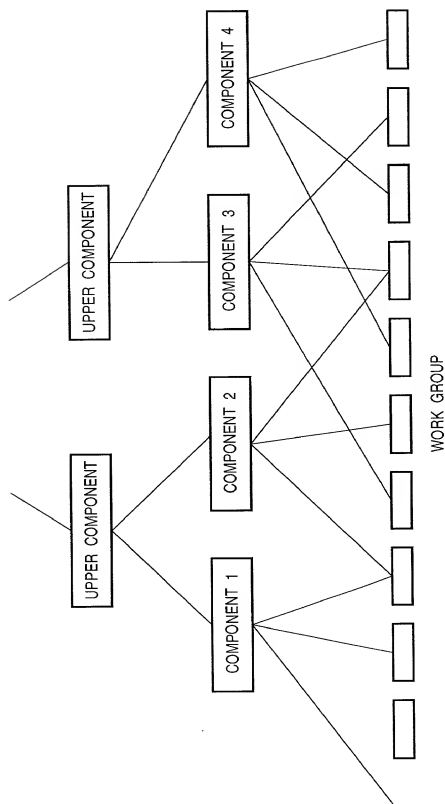
FIG. 49

FIG. 50

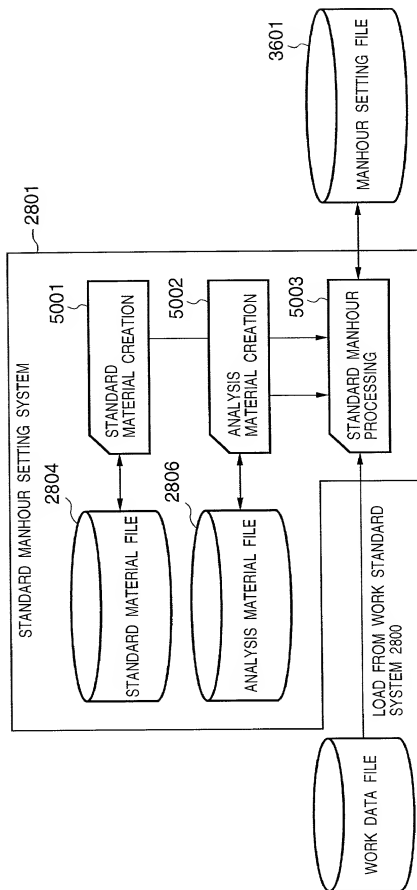


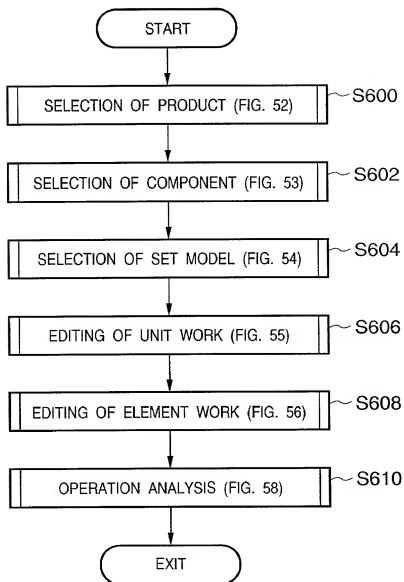
FIG. 51

FIG. 52

SELECTION OF PRODUCT

FILE(E) EDIT(E)

PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE
▶ BJ - 970909	XXXXXX	1997/09/22 10:17:30
BJ - STAND		1997/09/12 15:09:09
BJ - test	TEST 01 Standard	1997/09/18 10:38:14
BJ250	250 TESTS	1997/09/17 17:58:59
ST01	STAND PRODUCT	1997/09/12 16:02:34
STAND01		1997/09/19 15:46:04

SET MANHOUR
 EXTRACT DATA
 CREATE HOST TRANSFER
 ANALYZE DATA
 END

5201

FIG. 53

SELECTION OF COMPONENT

FILE(E) EDIT(E)

PRODUCT SYMBOL : BJ - 4200

NAME : BJ - 4200

COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE
<div> <div>▶ BK</div> <div>CH</div> <div>KO</div> </div>	<div>XXXX</div> <div>CHECK PROCESS PACKAGE</div>	<div>1997/09/22 11:09:59</div> <div>1997/09/12 11:09:59</div> <div>1997/09/18 11:21:07</div>

NEXT

DOWNLOAD

UPLOAD

BACK UP

LIST

CANCEL ACCESS FLAG

END

5301

FIG. 54

SELECTION OF MODEL

FILE(E)

EDIT(E)

VIEW(V)

X

PRODUCT NUMBER : BJ - 970909 NAME : 97 - 09 - 09 LOAD

COMPONENT SYMBOL : CH NAME :

SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▲ A250 IQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		XXXXX	1997/09/09 10:46:33
BJC - 430J			

NEXT

REGISTER PUBLICATION

LOOK PUBLICATION

DISPLAY SAME MODEL

END

FIG. 55

SELECTION OF MODEL									
FILE(E) EDIT(E) VIEW(V)									
PRODUCT SYMBOL : BJ-970909 NAME : 097-09-09 LOAD SET MODEL SYMBOL : BJ-4300 LATEST REVISION NUMBER UPDATE DISPLAY									
COMPONENT SYMBOL : ON NAME : xxxxxx									
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY		
▶ N ^o 3	CH-01-01	1	電気チェック	0	0	0	0	1	
N ^o 4	CH-01-02(1)	1	電気チェック	0	0	0	0	1	
N ^o 5	CH-01-02(2)	1	電気チェック	0	0	0	0	1	
N ^o 6	CH-01-03	1	電気チェック	0	0	0	0	1	
N ^o 7	CH-01-04	1	電気チェック	0	0	0	0	1	
N ^o 23	CH-07-02(1)	1	フロントカバーu取付	0	0	0	0	1	
N ^o 24	CH-07-02(2)	1	フロントカバーu取付	0	0	0	0	1	
N ^o 25	CH-07-01(3)	1	フロントカバーu取付	0	0	0	0	1	
N ^o 26	CH-07-01(4)	1	フロントカバーu取付	0	0	0	0	1	
UNIT WORK NAME MANHOUR USE FREQUENCY 1 2 3 4 5									
No. FORMAL MANAGEMENT NO.				ELECTRICAL CHECK					
3 CH-01-01				0 0 0 1					
<div> <input type="radio"/> CHANGE <input type="radio"/> INSERT <input type="radio"/> ADD </div> <div>OK</div>									

5501 5507 5506 5502 5503 5504 5505

FIG. 56

XXXXXX

FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME: MOTOR ATTACHMENT TOTAL MANHOUR: NEXT UNIT WORK

NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION
▶ 1	LFモータのケーブルと反対側の軸にタプトルギア	1	0	0		
*						

COMMENT 1 : LFモータのケーブルと反対側の軸に

OBJECT : タプトルギアを

COMMENT 2 : キア径の小さい方から

VERB : 取付ける

5604 5605 5603 5602 5601

FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MAN/ HOUR	USE	FREQUENCY	COUNT	SET	DATE
▶	I7-キヤプ7:	本体を	矢印1の様に	入れる	-50/G1/N>6/-3	15	0	1	1	0	97/09/09 9:52
	I7-キヤプ7:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	1	0	97/09/09 9:53
	I7-キヤプ7:	本体を	矢印1の様に	入れる	-50/G1/N>6/-3	15	0	1	1	0	97/09/09 9:55
		要素作業01		動詞	-50/G1/N>6/-3	15	0	1	1	0	97/09/10 16:34
	I7-キヤプ7:	本体を	矢印1の様に	入れる	-50/G1/N>6/-3	15	0	1	1	0	97/09/10 19:09
		キリッジ/ロク		塗布する	Time100/Rate100	100	100	1	1	1	97/09/10 19:16
	モータ組立:	アリンタヤーン		入れ、セットする	M211/1/10	50	1	1	1	1	97/09/11 17:00
		アリンタヤーン		裏面にする	T1221/M2311/0/0	12	0	1	1	0	97/09/11 17:34
	1			1	T2221/M1211/0/1	24	0	1	1	0	97/09/11 17:20
	2			2	T1221/M2311/0/0	12	0	1	1	0	97/09/11 17:24
		アリンタヤーン	PRカイト 取付ける	セットする		15	0	1	1	0	97/09/12 11:24
		oglatdflas		fcastdcastdflad	*	16	0	1	1	0	97/09/12 12:10
		dcastdflad		fcastdcastdflad	T21121/M1111/0/1	13	0	1	1	0	97/09/12 12:10
		oglatdflas		fcastdcastdflad	*	16	0	1	1	0	97/09/12 13:39
		アリンタヤーン	PRカイト 取付ける	セットする		15	0	1	1	0	97/09/12 14:00
		アリンタヤーン	PRカイト 取付ける	セットする		15	0	1	1	0	97/09/12 14:00
		アリンタヤーン	PRカイト 取付ける	セットする	Time100/Rate100	100	100	1	1	0	97/09/12 14:04

FIG. 58

OPERATION ANALYSIS				5801	5802	5803	5804	5805	
<div> </div>									
1 SET MAIN BODY TO PREDETERMINED POSITION				TOTAL SIMO VALUE :		0	TOTAL MAN-HOUR VALUE :		
						15	SIMO		
						NEXT ELEMENT WORK			
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MAN-HOUR	USE	REMARKS			
▲ 1	XXXXXX	PU	-60/G1/N1>61/3	15	0				
*									

FIG. 59

5901

1. PU
☐

6. DSY
☐

11. PU
☐

16. DSY
☐

2. GET
☐

7. R
☐

12. GET
☐

17. R
☐

3. M
☐

8. UMAC
☐

13. M
☐

4. MA
☐

9. MP
☐

14. MA
☐

5. ASY
☐

10. BODY
☐

15. ASY
☐

☐ SIMO

SELECT

CANCEL

5902

FIG. 60

XXXXXX					
PU		PICK UP		MANUAL	
1 :	MOVING DISTANCE	-10cm	+10cm	>50cm	
2 :	GRIP TYPE	Qr-3	Qr-2		
3 :	PRE-POSITIONING	NO	YES		
4 :	MAIN SIZE	-10mm	-6mm		
5 :	WEIGHT	<3Kg	>3Kg		
6 :					
SET		CANCEL	SET VALUE	FORMULA	
6001		6002		6003	

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET CANCEL SET VALUE

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 points to the title bar.

6202 points to the 'VARIATION AMOUNT' input field.

6203 points to the 'USE' input field.

6204 points to the 'CHANGE REASON' dropdown menu.

6205 points to the 'OK' button.

6206 points to the 'Clear' button.

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE
1997
09
22
=
O
FROM
O
BEFORE
O
~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MAN-HOUR	(NEW) USE	PREVIOUS (PREVIOUS) MAN-HOUR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	1997/09/22 14:30.00

REASON CODE
1
CHANGE REASON
SET

OK
CIR
END

FIG. 64

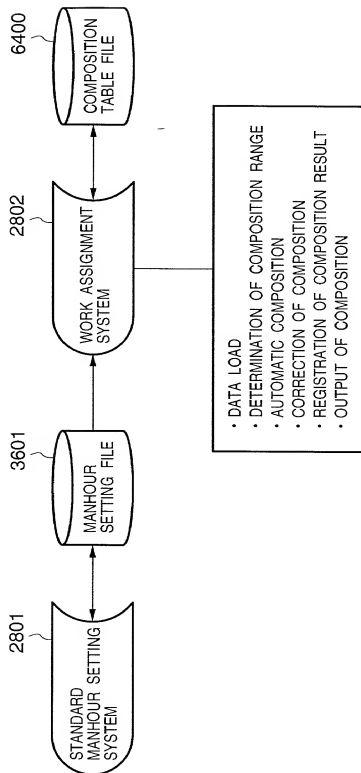


FIG. 65

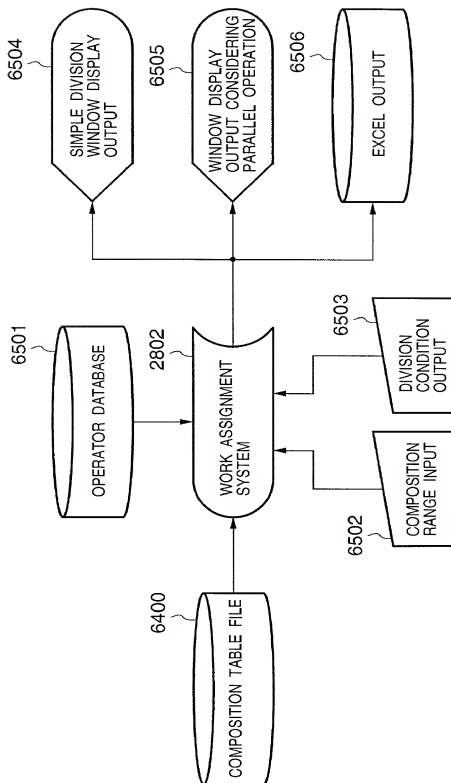


FIG. 66

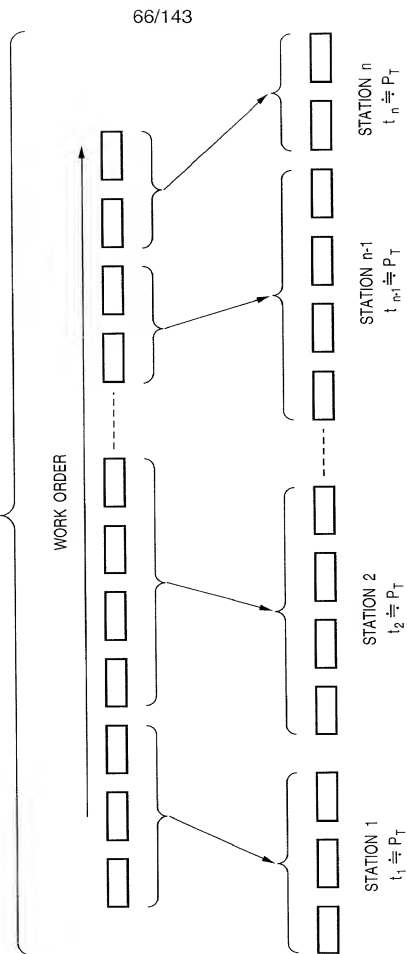


FIG. 67

		▲	
FILE(F) EDIT(E) INPUT(I) TOOL(O)		▼	

MODEL	GP55
UNIT	

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	385
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

...

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
FILE(F) EDIT(E)		◆	
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

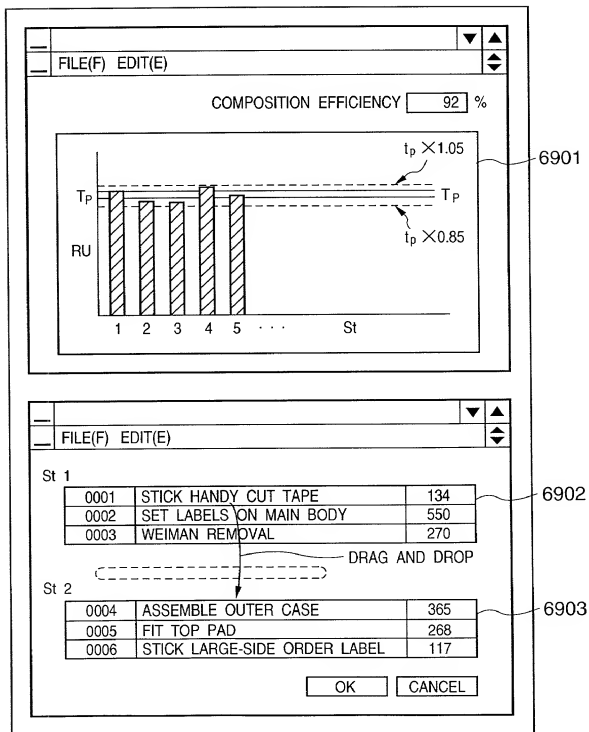


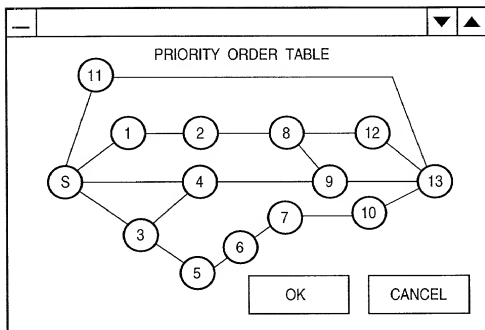
FIG. 70

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
		⋮			

FIG. 72

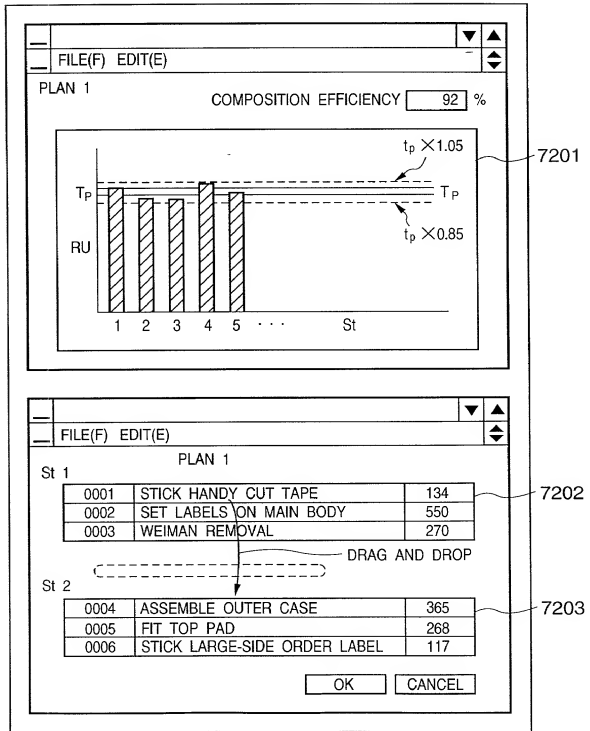


FIG. 73

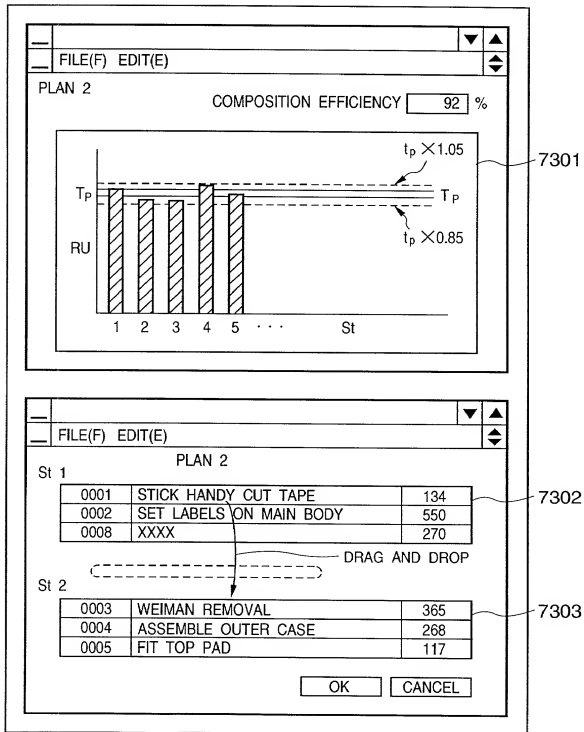


FIG. 74

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

GENRE

BJ
FAX
LBP
NP
STAND

REPRESENTATIVE
MODEL

TARGET MODEL

COMPONENT

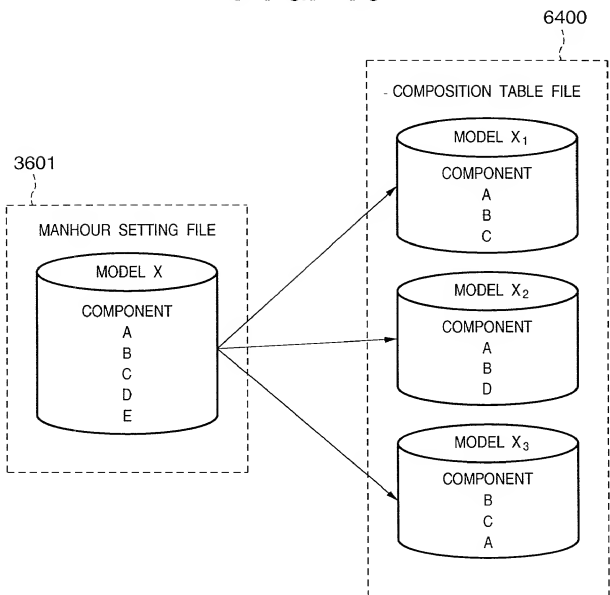
COMPONENT SYMBOL	COMPONENT NAME	ORDER

OK

CANCEL

7408

FIG. 75



[illegible][illegible]

FIG. 77

7706 7701 7702 7705 7703
7710a 7710b 7710c 7710d 7720a 7720b 7720c 7720d

INPUT OF COMPOSITION DATA

FILE#(E) ENT#(E) TOOL#(J)

COMPOSITION DATA

TARGET MODEL

PER1000

OPTION(Q)

FILE NAME (COMPOSITION NAME)

REVISION NUMBER

G

MA: PROVISIONAL

W F MANUAL CHINE MANHOOUR SECTION

W F MANUAL CHINE MANHOOUR SECTION

G.NO.

1	UNIT NAME	579	579	0	G	IN	SET
0	FIRST WORK NO.	WORK STANDARD NO.	W F MANUAL MANHOOUR	MANHOOUR	MANHOOUR	PROVISIONAL	SEC-COMPO-NENT
1	1	9000000000000000001E	単位名#61	579	579	0	0
1	2	9000000000000000001E	単位名#62	54	54	0	0
1	3	9000000000000000001E	単位名#63	10	10	0	0
1	4	9000000000000000001E	単位名#64	50	50	0	0
1	5	9000000000000000001E	単位名#65	53	53	0	0

OPTIONAL

OT TOOL

OPART

ONOTE

PRIORITY

COMPOSITION ORDER SCHEME

MODE

REMARKS

PRE-NO.	WOLUS
1	0
2	1
3	2
4	3
5	4
6	5
7	6
8	7
9	8
10	9
11	10
12	11
13	12
14	13
15	14
16	15
17	16
18	17
19	18
20	19
21	20
22	21
23	22
24	23
25	24
26	25
27	26
28	27
29	28
30	29
31	30
32	31
33	32
34	33
35	34

THE NUMBER OF WORKS IN COMPOSITION : 141

TOTAL : 11933 (RU)

TOTAL MANHOOUR IN COMPOSITION : 11933 (RU)

TOTAL MANHOOUR OUTSIDE WORKSHOP : 0 (RU)

7706 7701 7702 7705 7703

7710a 7710b 7710c 7710d 7720a 7720b 7720c 7720d

INPUT DATA

THE EXPECTED NUMBER OF PRODUCTS: 690 UNITS

THE NUMBER OF DEFECTIVE PRODUCT: 0 UNITS

THE NUMBER OF INITIAL PRODUCTS INVESTED INTO TOP OF ASSEMBLY LINE: 595 UNITS

MIN. LINES: 450

WORKING TIME: 450

BREAK: 15

MORNING MEETING TIME: 1 MIN.

EXERCISE TIME: 5 MIN.

LINE STOP TIME: 0 MIN.

OTHERS: 0 MIN.

OPERABLE TIME: 429 UNITS

EXPECTED COMPOSITION EFFICIENCY: 95 %

CALCULATE

OUTPUT DATA (ROUND DOWN)

STATION COMPOSITION EFFICIENCY: 181 %

STATION (ROUND UP): 100 %

COMPOSITION EFFICIENCY: 19 %

COMPOSITION EFFICIENCY: 95 %

THE NUMBER OF STATIONS: 19 %

COMPOSITION EFFICIENCY: 95 %

CALCULATION RESULT

THE NUMBER OF STATIONS: 189 %

PITCH TIME (P): 690 RU

EXECUTE COMPOSITION: END

FIG. 78

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

7801

PROVISIONAL MANHOUR : (RU)

7802

REMARKS :

OK CANCEL

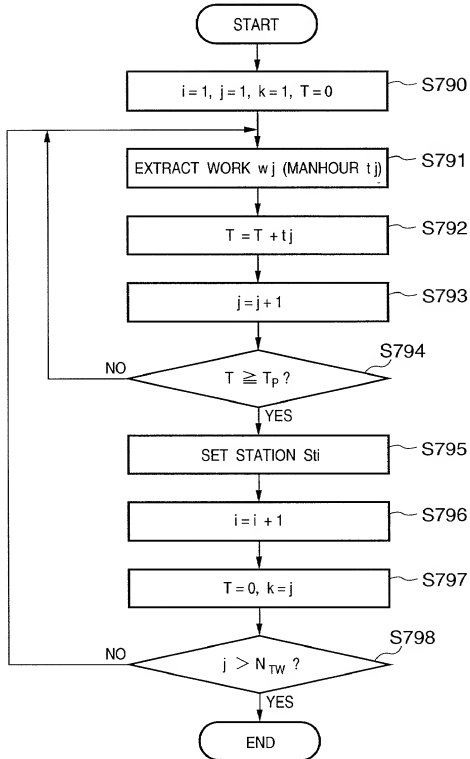
FIG. 79

FIG. 80

FILE(F) EDIT(E) VIEW(V) TOOL(T)

8001 OPERATOR 1

8002 OPERATOR 2

8003 OPERATOR 3

8004 OPERATOR 4

8005 OPERATOR 5

8006

8007

8008

8009

8010

8011

8012

8013

8014

8015

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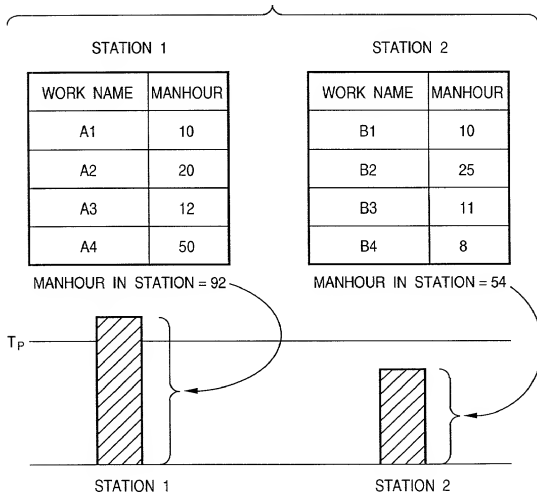
FIG. 81

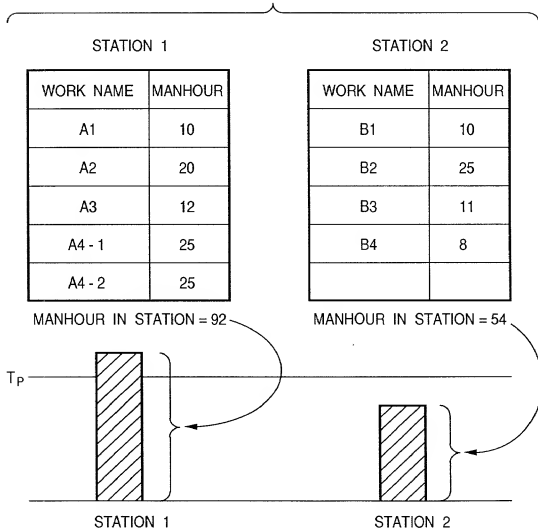
FIG. 82

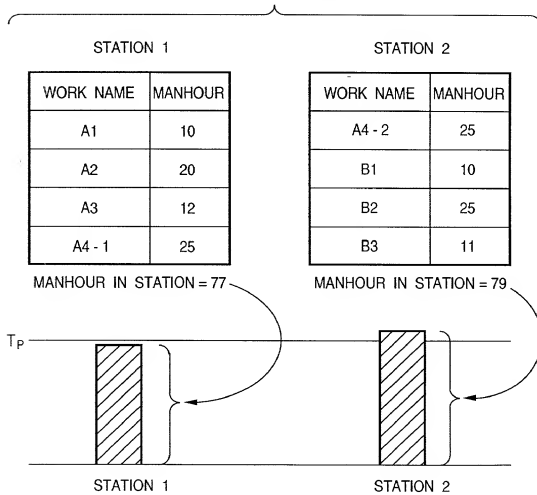
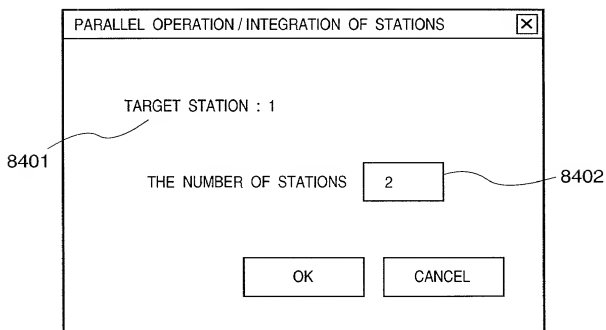
FIG. 83

FIG. 84

FILE EDIT VIEW TOOL

OPERATOR 1

OPERATOR 2

OPERATOR 3

OPERATOR 4

OPERATOR 5

S1			S2			S3			S4			S5		
WORK NAME	PROV. MAN-CHINE	MAN-CHINE	WORK NAME	PROV. MAN-CHINE	MAN-CHINE	WORK NAME	PROV. MAN-CHINE	MAN-CHINE	WORK NAME	PROV. MAN-CHINE	MAN-CHINE	WORK NAME	PROV. MAN-CHINE	MAN-CHINE
UNIT WORK	WF	WF	UNIT WORK	WF	WF	UNIT WORK	WF	WF	UNIT WORK	WF	WF	UNIT WORK	WF	WF
START	0	0	UNIT WORK 155	0	No.03	UNIT WORK 30	40	No.13	UNIT WORK 84	26	No.19	UNIT WORK 146	71	No.22
UNIT WORK 34	10	No.01	NAME 3	0	No.04	NAME 13	0	No.04	NAME 20	0	No.20	NAME 23	106	No.23
UNIT WORK 255	48	No.02	NAME 4	0	No.04	NAME 18	0	No.04	NAME 21	0	No.21	NAME 24	0	No.24
UNIT WORK 52	26	No.06	NAME 5	0	No.04	NAME 300	131	No.18	NAME 27	66	No.21	NAME 28	91	No.25
UNIT WORK 52	0	No.07	NAME 10	0	No.10				NAME 310	310	No.21	NAME 29	0	No.25
UNIT WORK 52	0	No.08	NAME 11	0	No.11				NAME 31	0	No.21	NAME 30	0	No.25
UNIT WORK 52	0	No.09	NAME 12	0	No.12				NAME 21	0	No.21	NAME 31	0	No.25
UNIT WORK 38	0	No.14	NAME 13	0	No.14							NAME 32	0	No.25
UNIT WORK 46	18	No.15	NAME 14	0	No.15							NAME 33	0	No.25
UNIT WORK 546	15	No.16	NAME 15	0	No.16							NAME 34	0	No.25
UNIT WORK 58	20	No.17	NAME 16	0	No.17							NAME 35	0	No.25
UNIT WORK 58	20	No.17	NAME 17	0	No.17							NAME 36	0	No.25
TOTAL 585 (RU)			TOTAL 1548 (RU) xxxxxxxx			TOTAL 572 (RU)			TOTAL 623 (RU)			TOTAL 486 (RU)		
PF 83.8%			PF 23.3%			PF 98.7%			PF 96.2%			PF 73.8%		

PARALLEL STATIONS

1

2

3

4

5

G STANDARD NO.

WORK NAME

WF

MEANS

PROVISIONAL MAN-CHINE

REMARKS

to

to+1.05

to+0.85

COMPOSITION EFFICIENCY

116%

NET COMPOSITION EFFICIENCY

116%

COMPOSITION MODE: PRIORITY ORDER SCHEME

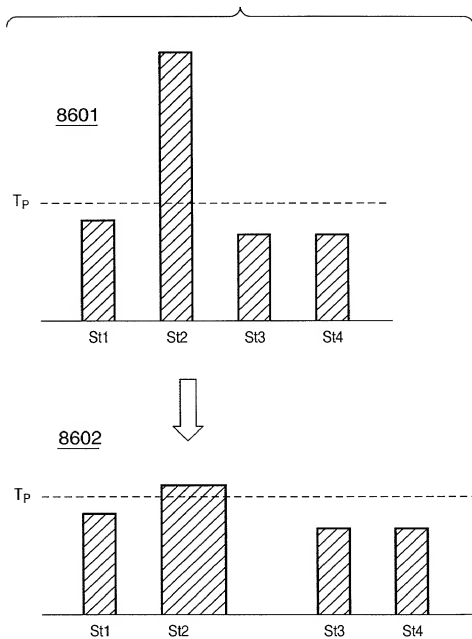
FIG. 86

FIG. 87

A screenshot of a 'USER REGISTRATION' dialog box. The dialog has a title bar with the text 'USER REGISTRATION' and a close button (X). Inside the dialog, there are five input fields with labels to their left: 'NAME CODE :', 'NAME :', 'POSITION :', 'PASSWORD :', and 'AUTHORITY :'. The 'NAME CODE' field contains '12345'. The 'NAME' field is split into two boxes containing '田中' and '一郎'. The 'POSITION' field contains 'kumitate' and has a dropdown arrow on the right. The 'PASSWORD' field contains '12345'. The 'AUTHORITY' field is empty. At the bottom of the dialog are two buttons: 'OK' and 'CANCEL'. On the right side of the image, there are five reference numbers (8701, 8702, 8703, 8704, 8705) with wavy lines pointing to the input fields: 8701 points to the Name Code field, 8702 points to the first part of the Name field, 8703 points to the second part of the Name field, 8704 points to the Password field, and 8705 points to the Authority field.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

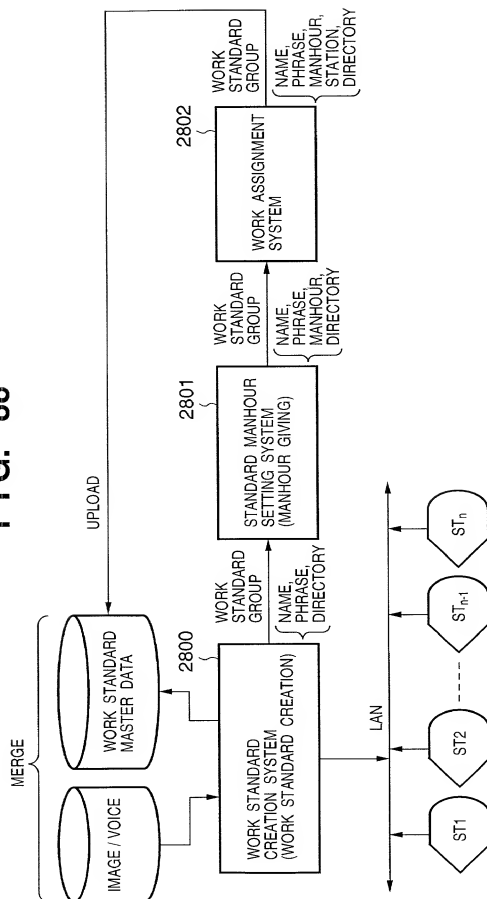


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

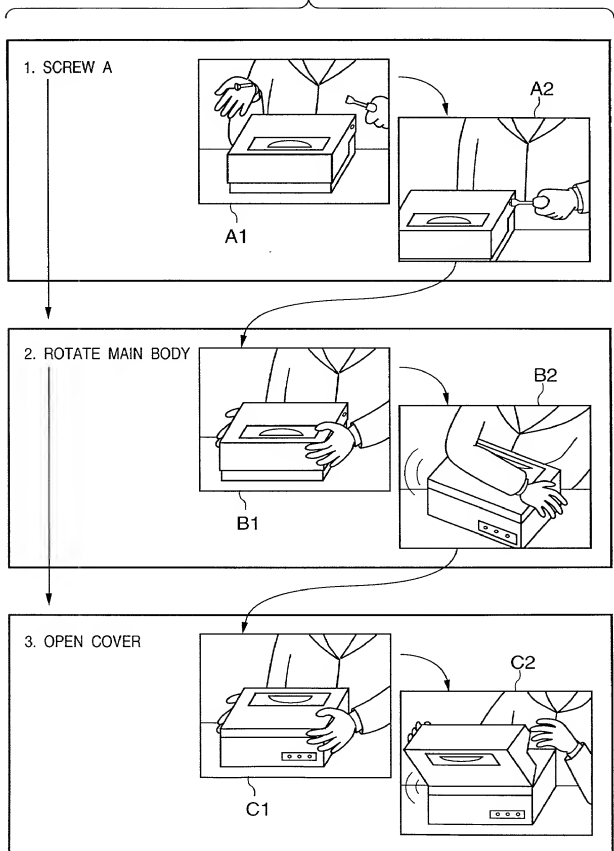
FIG. 90

FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

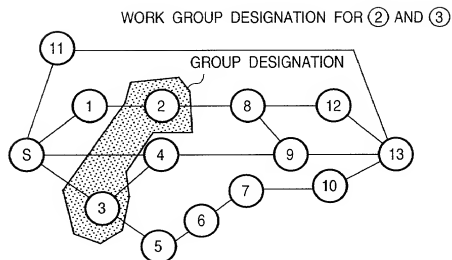
FIG. 92

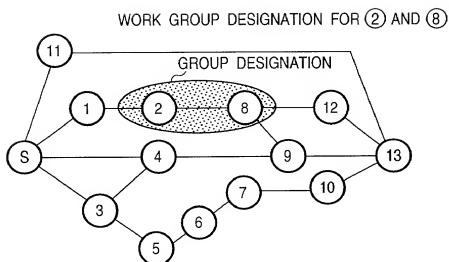
FIG. 93

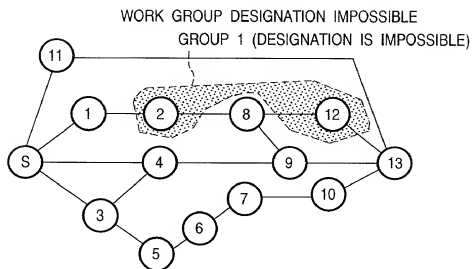
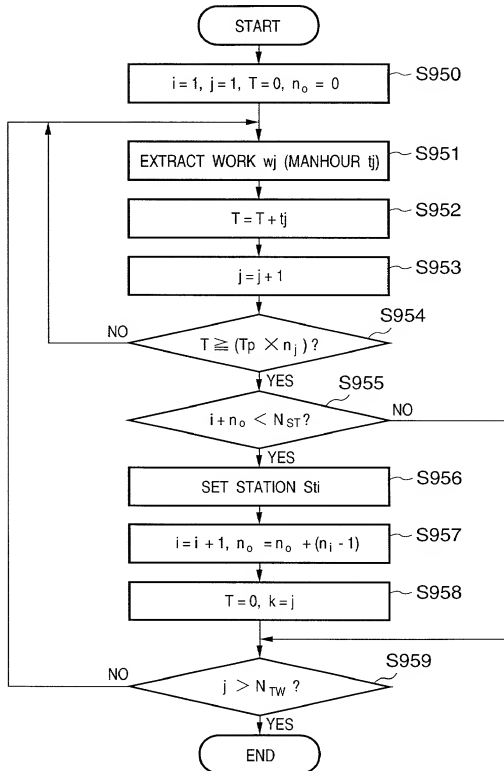
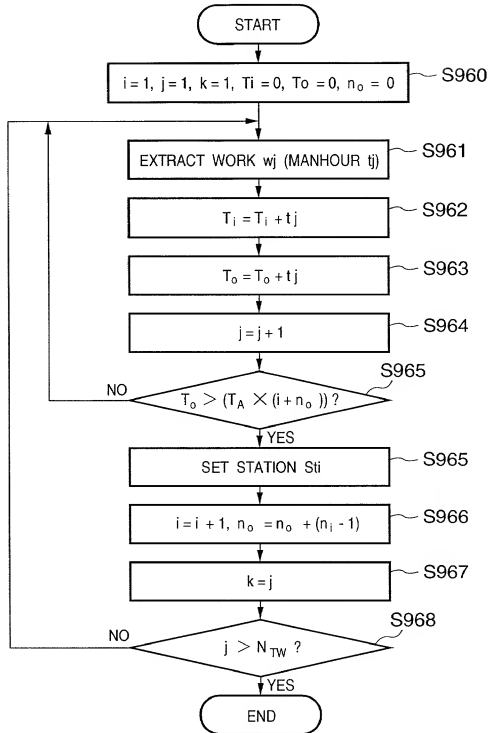
FIG. 94

FIG. 95

N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 96

N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOURL

T_A : STATION MANHOURL AVERAGE VALUE

$$T_A = WF / N_{ST}$$

T_o : TOTAL ACCUMULATED MANHOURL

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 98A

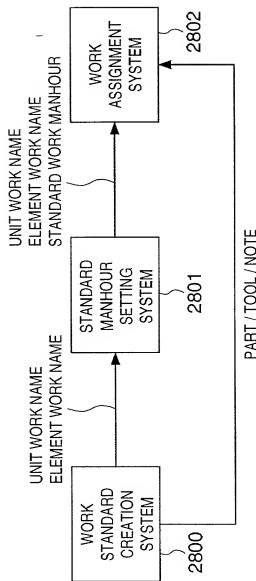


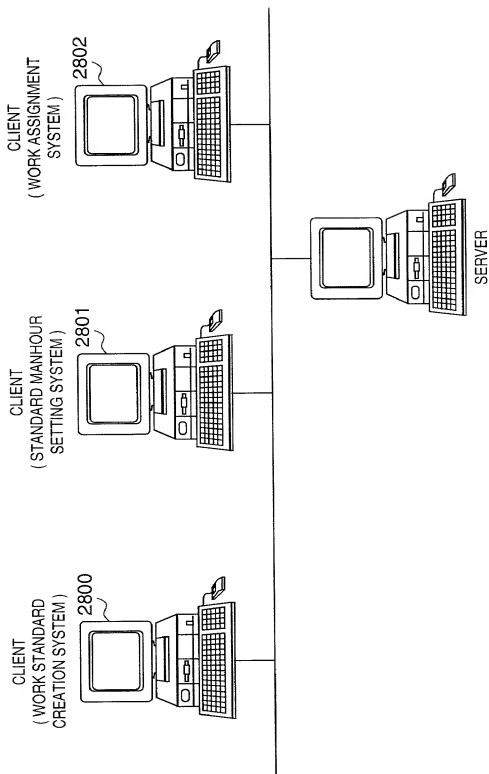
FIG. 98B

FIG. 99A

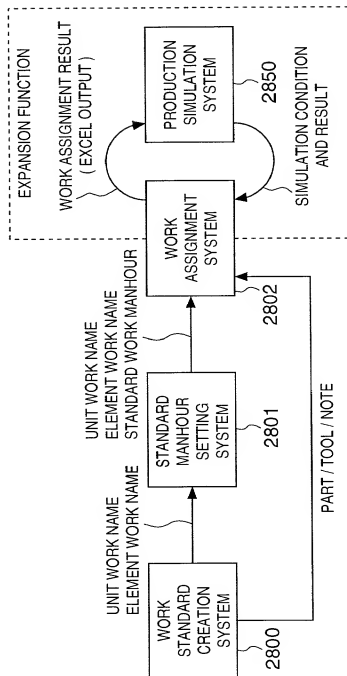


FIG. 99B

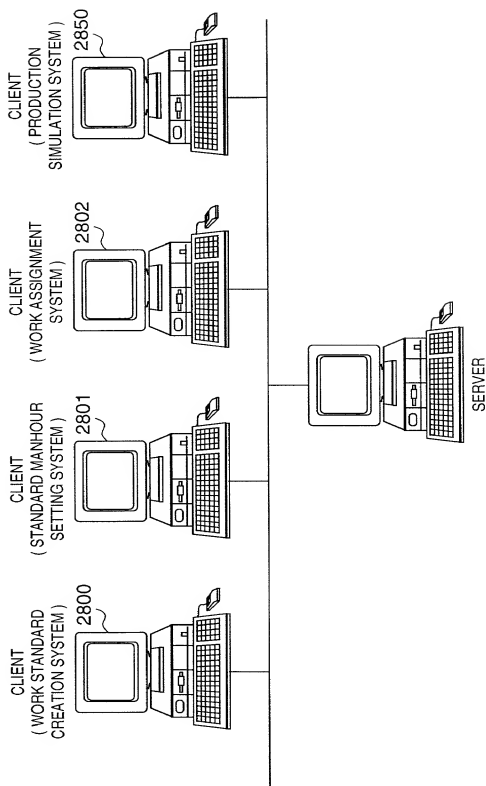


FIG. 100

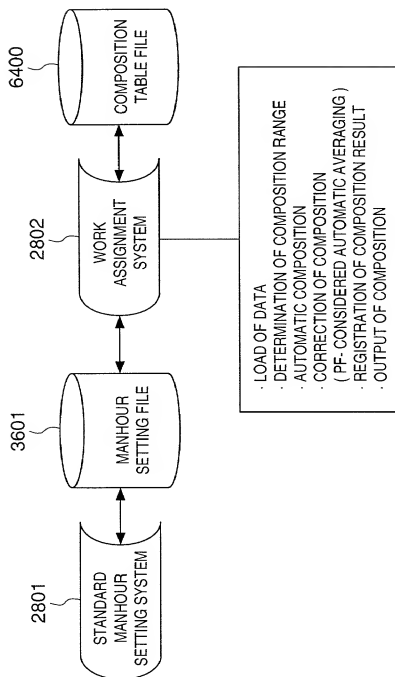


FIG. 101

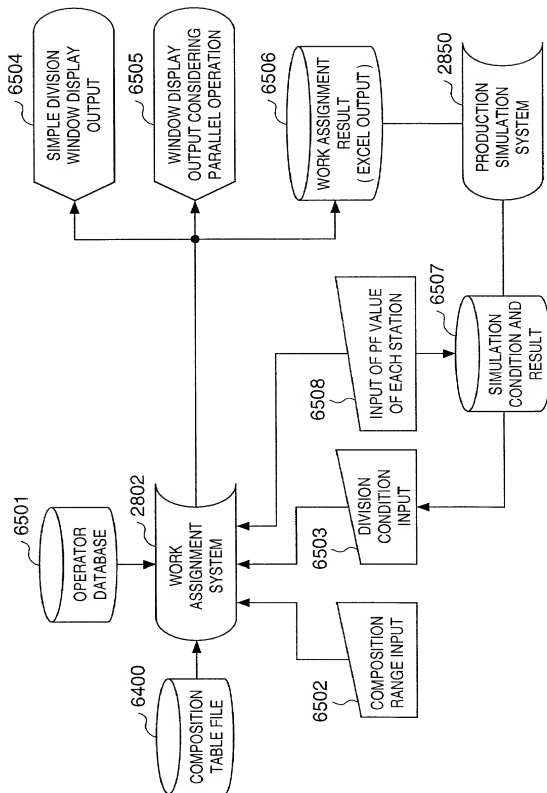
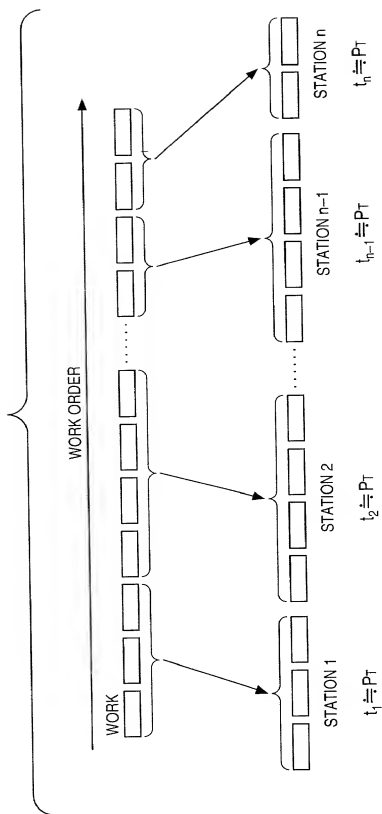


FIG. 102



PT : PITCH TIME
 $t_1 \dots t_n$: STATION MANHOUR

FIG. 103

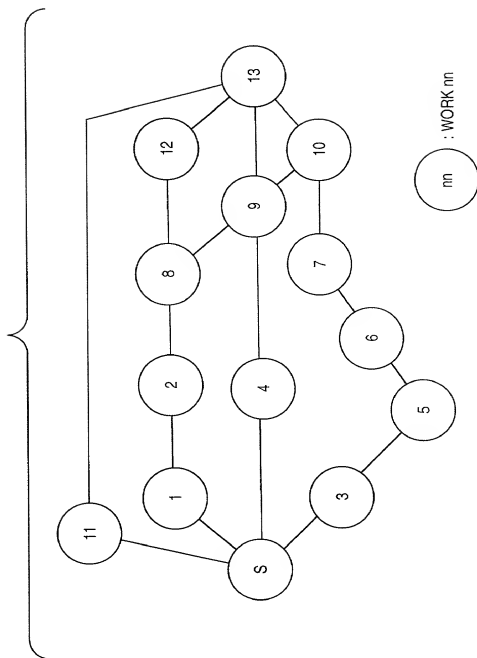
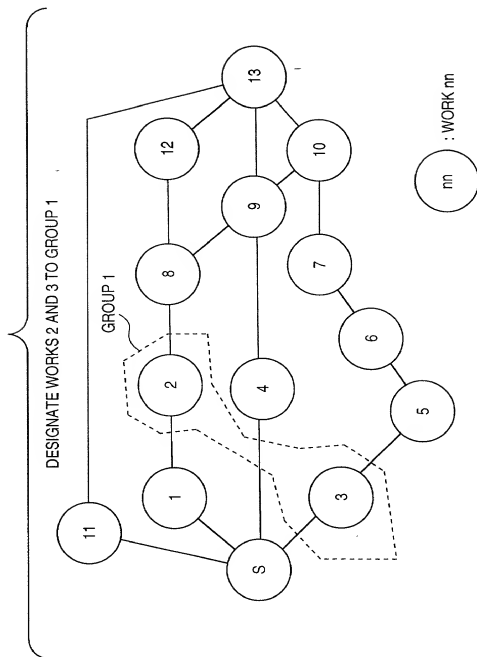


FIG. 104

INPUT OF COMPOSITION DATA

FILE(E) EDIT(E) TOOL(T) CHANGE WORK ORDER(M) OPTION(O)

COMPOSITION DATA

TARGET FILE NAME

REVISION NUMBER

MODEL (COMPOSITION NAME)

NUMBER

G

PER(100) TEST CASE

01

WORK O TOOL O PART O

COMPOSITION PRIORITY

MODE ORDER SCHEME

PROVISIONAL SECTION

MANUFACTURE

MANPOWER

COMPONENT

REMARKS

GNO.	STANDARD NO.	WORK NAME	W1	W2	W3	W4	W5	W6	W7	W8	W9	W10	W11	W12	W13	W14	W15	W16	W17	W18	W19	W20	W21	W22	W23	W24	W25	W26	W27	W28	W29	W30	W31	W32	W33	W34	W35	W36	W37	W38	W39	W40	W41	W42	W43	W44	W45	W46	W47	W48	W49	W50	W51	W52	W53	W54	W55	W56	W57	W58	W59	W60	W61	W62	W63	W64	W65	W66	W67	W68	W69	W70	W71	W72	W73	W74	W75	W76	W77	W78	W79	W80	W81	W82	W83	W84	W85	W86	W87	W88	W89	W90	W91	W92	W93	W94	W95	W96	W97	W98	W99	W100	W101	W102	W103	W104	W105	W106	W107	W108	W109	W110	W111	W112	W113	W114	W115	W116	W117	W118	W119	W120	W121	W122	W123	W124	W125	W126	W127	W128	W129	W130	W131	W132	W133	W134	W135	W136	W137	W138	W139	W140	W141	W142	W143	W144	W145	W146	W147	W148	W149	W150	W151	W152	W153	W154	W155	W156	W157	W158	W159	W160	W161	W162	W163	W164	W165	W166	W167	W168	W169	W170	W171	W172	W173	W174	W175	W176	W177	W178	W179	W180	W181	W182	W183	W184	W185	W186	W187	W188	W189	W190	W191	W192	W193	W194	W195	W196	W197	W198	W199	W200	W201	W202	W203	W204	W205	W206	W207	W208	W209	W210	W211	W212	W213	W214	W215	W216	W217	W218	W219	W220	W221	W222	W223	W224	W225	W226	W227	W228	W229	W230	W231	W232	W233	W234	W235	W236	W237	W238	W239	W240	W241	W242	W243	W244	W245	W246	W247	W248	W249	W250	W251	W252	W253	W254	W255	W256	W257	W258	W259	W260	W261	W262	W263	W264	W265	W266	W267	W268	W269	W270	W271	W272	W273	W274	W275	W276	W277	W278	W279	W280	W281	W282	W283	W284	W285	W286	W287	W288	W289	W290	W291	W292	W293	W294	W295	W296	W297	W298	W299	W300	W301	W302	W303	W304	W305	W306	W307	W308	W309	W310	W311	W312	W313	W314	W315	W316	W317	W318	W319	W320	W321	W322	W323	W324	W325	W326	W327	W328	W329	W330	W331	W332	W333	W334	W335	W336	W337	W338	W339	W340	W341	W342	W343	W344	W345	W346	W347	W348	W349	W350	W351	W352	W353	W354	W355	W356	W357	W358	W359	W360	W361	W362	W363	W364	W365	W366	W367	W368	W369	W370	W371	W372	W373	W374	W375	W376	W377	W378	W379	W380	W381	W382	W383	W384	W385	W386	W387	W388	W389	W390	W391	W392
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37708

FIG. 106

9003 ☐ CORRECTION OF COMPOSITION DATA
☐ FILE ☐ EDIT ☐ VIEW ☐ TOOL ☐

9004 ☐ SAVE(S) ☐ SAVE AS(A) ☐ DELETED(D) ☐ PREVIOUS WINDOW(P) ☐ EXCEL OUTPUT ☐ WORK ASSIGNMENT SYSTEM(X)

9001

9002

S1				S2				S3				S4				S5			
STANDARD	PROV. MAN- HOUR	WORK NAME	WF	STANDARD	PROV. MAN- HOUR	WORK NAME	WF	STANDARD	PROV. MAN- HOUR	WORK NAME	WF	STANDARD	PROV. MAN- HOUR	WORK NAME	WF	STANDARD	PROV. MAN- HOUR		
電気・ 責任 チェツ 調整	0	0	S0-0	メイン ケース フロ ント カバ	0	0	S0-0	印字 検査	0	0	CH-0	外観 検査	116	0	CH-0	外観 検査	270	0	
電気・ 責任 チェツ 調整	256	0	S0-0	出機 印字	0	0	CH-0	内観 検査	115	0	CH-0	本体 テープ 貼付	77	0	K0-0	本体 テープ 貼付	61	0	
紙間 調整	128	0	S0-0																
紙間 調整	325	0	S0-0																
紙間 調整	364	0	S0-0																
紙間 調整	40	0	S0-0																
TOTAL 1470(RU)	3000			TOTAL 1795(RU)	PF 92.6%			TOTAL 1483(RU)	PF 86.8%			TOTAL 1656(RU)	PF 96.9%						
3000	2250																		
1500	750																		
750	0																		

G STANDARD NO. WORK NAME WF MANUAL MACHINE REMARKS

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY %

NET COMPOSITION EFFICIENCY %

--- tp
--- tp * 1.05
--- tp * 0.85

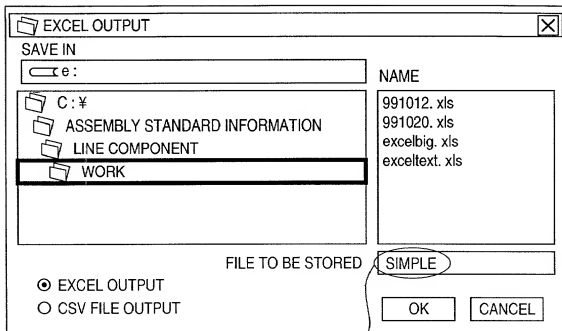
FIG. 107

FIG. 108

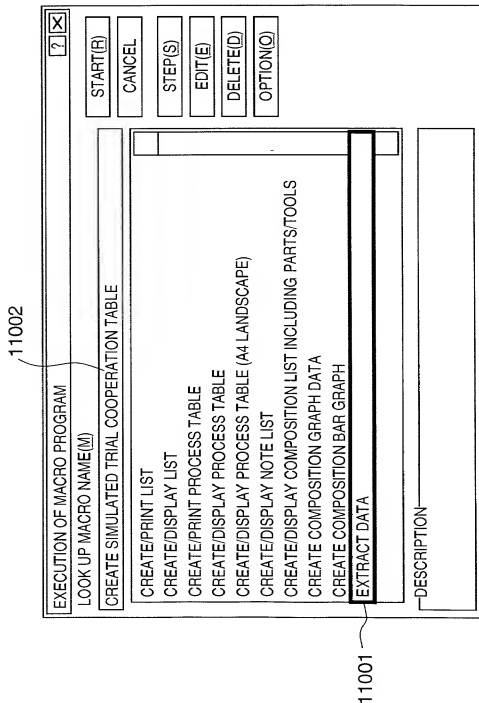


FIG. 109

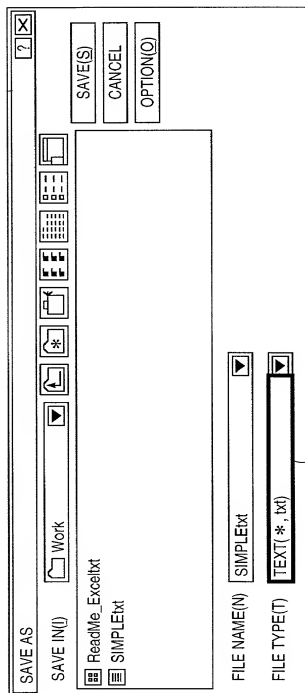


FIG. 110

SIMPLEX-WORD PAD

FILE(F) EDIT(E) SEARCH(S) INSERT(I) FORMAT(O) HELP(H)

Station ProcTimeRU pf pILower pILUpper WalkTimeRU1 WalkTimeRU2 BufSize1 BufSize2

Station 1	1622	100	100	100	0	0	0	0
Station 2	1630	100	100	100	0	0	0	0
Station 3	1644	100	100	100	0	0	0	0
Station 4	1808	100	100	100	0	0	0	0
Station 5	1724	100	100	100	0	0	0	0
Station 6	1722	100	100	100	0	0	0	0
Station 7	1753	100	100	100	0	0	0	0

PRESS F1 TO SEE HELP

13001 13002 13003 13004 13005

NUM

FIG. 111

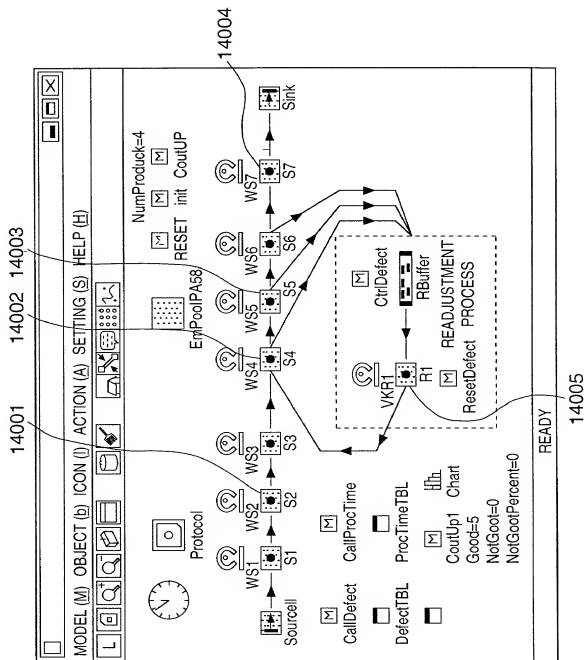


FIG. 112

	string 0	real 1	real 2	real 3	real 4
string Station		proc. time	pf	pfdown	pfup
1	S1	1622	90.00	84.30	96.10
2	S2	1630	86.90	81.20	93.00
3	S3	1644	100.00	94.30	106.10
4	S4	1808	120.00	114.30	126.10
5	S5	1724	130.00	124.30	136.10
6	S6	1722	110.00	104.30	116.10
7	S7	1753	106.15	100.45	112.25
8					
9					

READY

FIG. 113

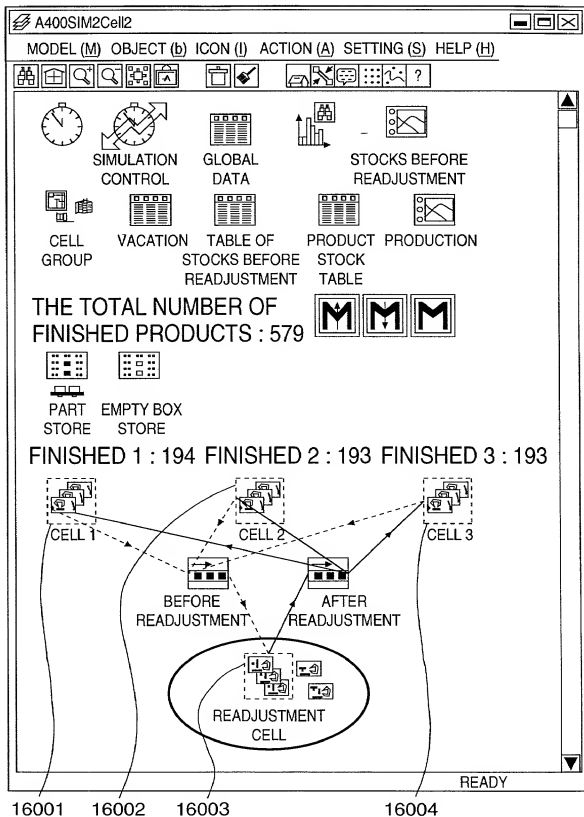


FIG. 114A

A400A IM4Cell7MarkManagerProoTimeTable

FILE(F) EDIT(E) FORMAT ACTION(A) SETTINGS(S) OTHERS(X) HELP(H)

=

	object 1	object 2	object 3	real 4	real 5	real 6	real 7
atri	Station	ParsTable	LinesideBuffer	ProcTimeRU	pf	pfLower	pfUpper
1	A400SIM4.Cel117 tenacshi1	A400SIM4.		17500.0000	100.00	75.00	149.00
2	A400SIM4.Cel117 tenacshi2	A400SIM4.		17500.0000	100.00	75.00	149.00
3	A400SIM4.Cel117 tenacshi3	A400SIM4.		17500.0000	100.00	75.00	149.00
4							

READY

17002

FIG. 114B

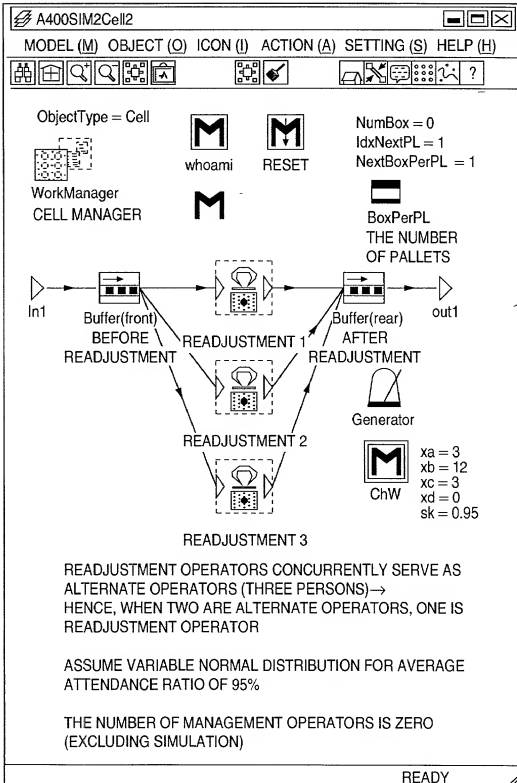


FIG. 115

SIMPLEEX.txt-MEMO PAD									
FILE(F) EDIT(E) SEARCH(S) HELP(H)									
Station	ProcTimeRU	pf	ptLower	ptUpper	WalkTimeRU1	WalkTimeRU2	BufSize1		
Station 1	1622	90	84	96	0	0	0		
Station 2	1630	87	81	93	0	0	0		
Station 3	1644	100	94	106	0	0	0		
Station 4	1808	120	114	126	0	0	0		
Station 5	1724	130	124	136	0	0	0		
Station 6	1722	110	104	116	0	0	0		
Station 7	1753	106	100	112	0	0	0		
18001								18002	18003 18004 18005

FIG. 116

19010

19005 CORRECTION OF COMPOSITION DATA

FILE(I) EDIT(I) VIEW(I) TOOL(I) AVERAGE (PF-CONSIDERED) AVERAGE(AUTO) SEARCH(AVERAGE (AUTO))

19006 AVERAGE(AUTO) SEARCH(AVERAGE (AUTO)) DIVIDE AT ONCE S3

19007 SEARCH DIVIDE AT ONCE S4

WORK NAME S5

STANDARD

PROV. S1 S2 S3 S4 S5 S6 S7

S1 S2 S3 S4 S5 S6 S7

MAN HOUR

1759RU 1598RU 1474RU 2000RU 1600RU 1683RU 1812RU

30% 87% 100% 100% 130% 10% 106%

1544RU 1493RU 1716RU 2059RU 2231RU 1188RU 1819RU

OPERATOR

NAME

OK CANCEL

19008

PROCESS CURRENT PROCESS SET PF VALUE

MAN HOUR

1759RU 1598RU 1474RU 2000RU 1600RU 1683RU 1812RU

30% 87% 100% 100% 130% 10% 106%

1544RU 1493RU 1716RU 2059RU 2231RU 1188RU 1819RU

OPERATOR

NAME

OK CANCEL

19009

19010

19011

19012

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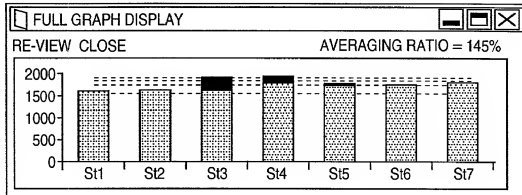
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20074

20075

FIG. 117A

BEFORE PF-CONSIDERED AUTOMATIC AVERAGING

**FIG. 117B**

AFTER PF-CONSIDERED AUTOMATIC AVERAGING

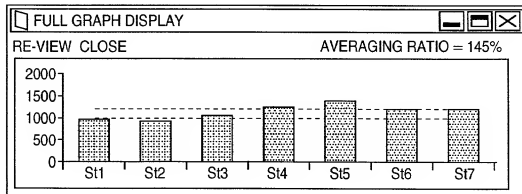


FIG. 118A

BEFORE PF-CONSIDERED
AUTOMATIC AVERAGING

PROCESS NO.	CURRENT PROCESS MAN/ HOUR	SET PF VALUE	tp * PF	OPERATOR NAME
S11	1755RU	90%	1544RU	
S12	1599RU	87%	1493RU	
S13	1474RU	100%	1716RU	
S14	2000RU	120%	2059RU	
S15	1600RU	130%	2231RU	
S16	1633RU	110%	1888RU	
S17	1812RU	106%	1819RU	

2001 2002 2003 2004 20006

OK CANCEL

FIG. 118B

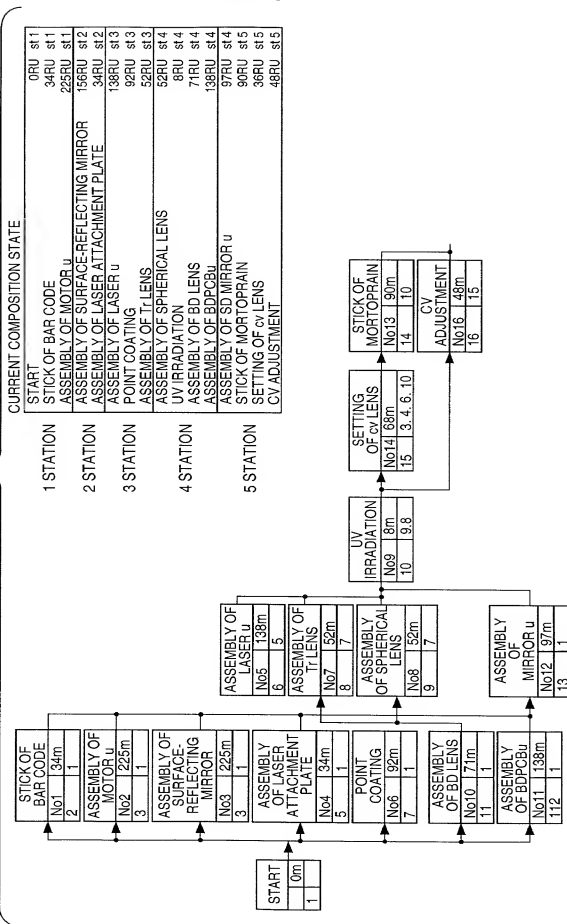
AFTER PF-CONSIDERED
AUTOMATIC AVERAGING

PROCESS NO.	CURRENT PROCESS MAN/ HOUR	SET PF VALUE	tp * PF	OPERATOR NAME
S11	1428RU	90%	1544RU	
S12	1330RU	87%	1493RU	
S13	1594RU	100%	1716RU	
S14	1936RU	120%	2059RU	
S15	2075RU	130%	2231RU	
S16	1737RU	110%	1888RU	
S17	1733RU	106%	1819RU	

STANDARD MAN/ HOUR OF STATION AFTER
PF-CONSIDERED AUTOMATIC AVERAGING

OK CANCEL

FIG. 119



123/143

START

FIG. 120

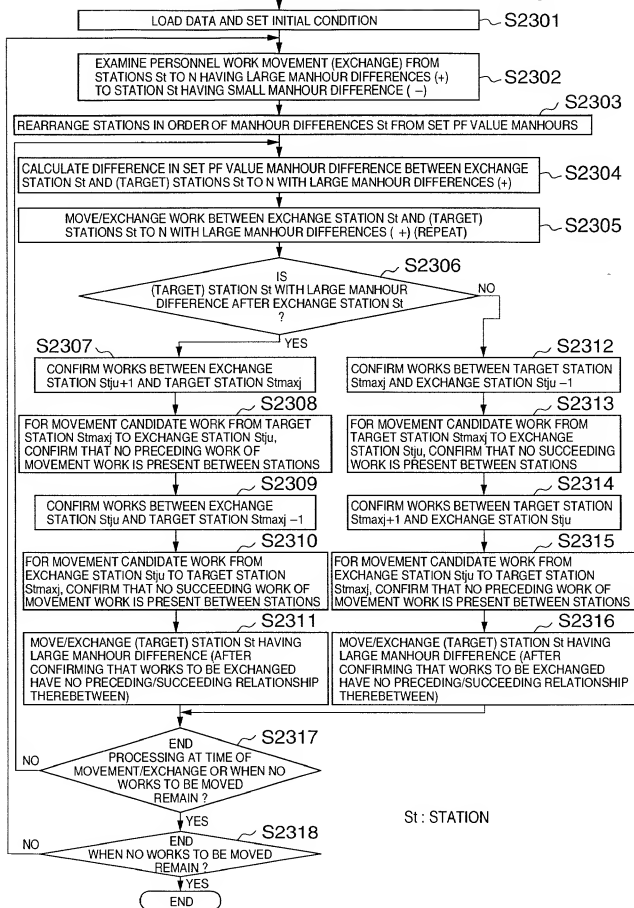


FIG. 121

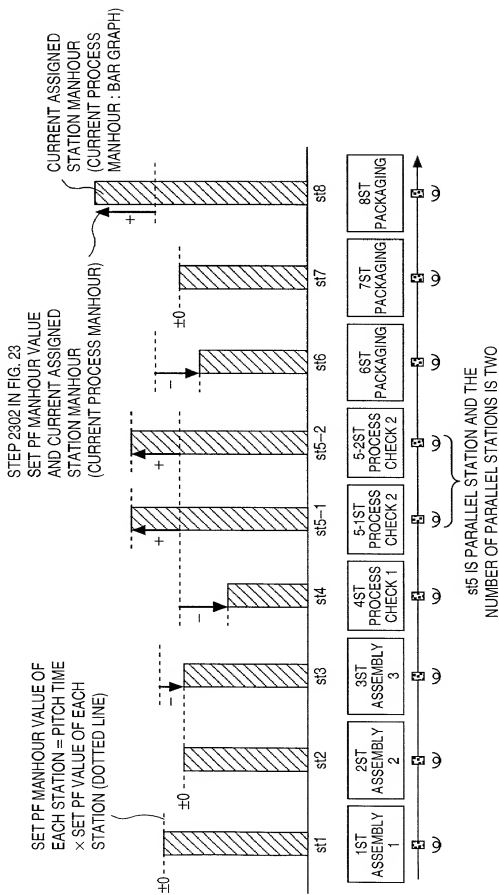


FIG. 122

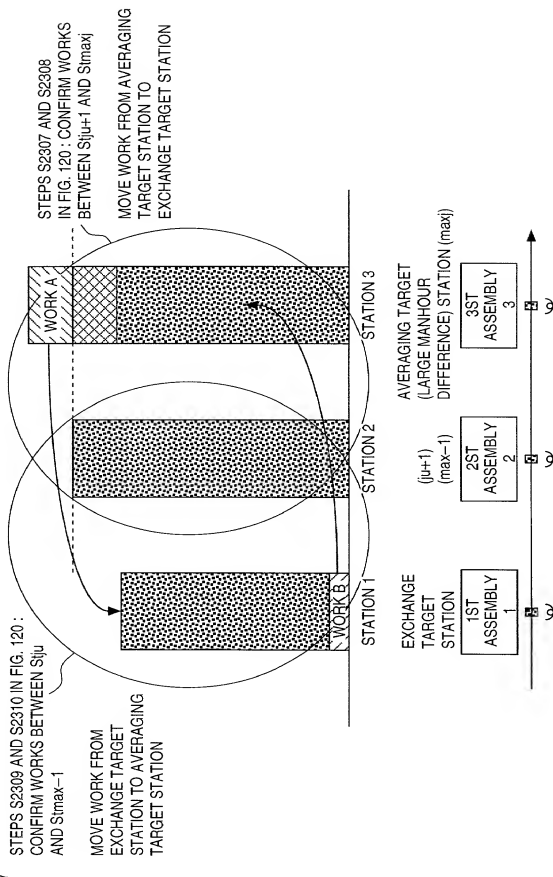


FIG. 123

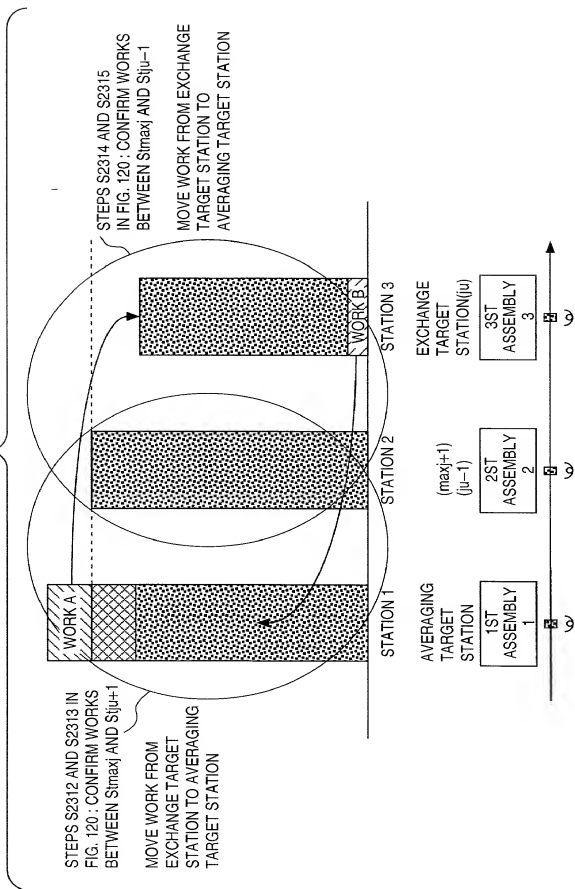


FIG. 124

32708

32707

32706

FIG. 125

TOOL ID: 82252680

CORRECTION OF COMPOSITION DATA

FILE(E) EDIT(E) VIEW(I) TOOL(I)

S1				S2				S3				S4				S5			
WORK NAME	WF	PROV. STAN- DARD	MAN- HOUR	WORK NAME	WF	PROV. STAN- DARD	MAN- HOUR	WORK NAME	WF	PROV. STAN- DARD	MAN- HOUR	WORK NAME	WF	PROV. STAN- DARD	MAN- HOUR	WORK NAME	WF	PROV. STAN- DARD	MAN- HOUR
単位 名称 s1	579	0	9000	単位 名称 u8	110	0	9000	単位 名称 u15	35	0	9000	単位 名称 m3	73	0	9000	単位 名称 m12	0	0	9000
単位 名称 s2	54	0	9000	単位 名称 u9	144	0	9000	単位 名称 u16	56	0	9000	単位 名称 m4	0	0	9000	単位 名称 m13	16	0	9000
単位 名称 s6	21	0	9000	単位 名称 u20	118	0	9000	単位 名称 u31	128	0	9000	単位 名称 m19	30	0	9000	単位 名称 m15	68	0	9000
単位 名称 s7	32	0	9000	単位 名称 m1	31	0	9000	単位 名称 u32	40	0	9000	単位 名称 m20	245	0	9000	単位 名称 m16	81	0	9000
TOTAL 1192(RU) PF 85.3%				TOTAL 1200(RU) PF 85.9%				TOTAL 1197(RU) PF 85.7%				TOTAL 1182(RU) PF 84.6%				TOTAL 1169(RU) PF 83.7%			

28001

28002

PROVISIONAL

G STANDARD NO. WORK NAME WF MANUAL MACHINE REMARKS

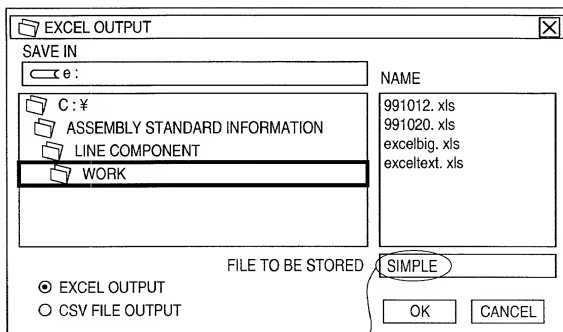
--- tp 1.05

--- tp * 0.85

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 85.22 %

NET COMPOSITION EFFICIENCY %

FIG. 126

29001

FIG. 127

EXECUTION OF MACRO PROGRAM

LOOK UP MACRO NAME(M)

CREATE SIMULATED TRIAL COOPERATION TABLE

CREATE/PRINT LIST

CREATE/DISPLAY LIST

CREATE/PRINT PROCESS TABLE

CREATE/DISPLAY PROCESS TABLE

CREATE/DISPLAY PROCESS TABLE (A4 LANDSCAPE)

CREATE/DISPLAY NOTE LIST

CREATE/DISPLAY COMPOSITION LIST INCLUDING PARTS/TOOLS

CREATE COMPOSITION GRAPH DATA

CREATE COMPOSITION BAR GRAPH

EXTRACT DATA

DESCRIPTION

30001

START(R)

CANCEL

STEP(S)

EDIT(E)

DELETE(D)

OPTION(O)

FIG. 128

SAVE AS

SAVE IN(I) Work

ReadMe_Excel.txt
SIMPLE.txt

FILE NAME(N) SIMPLE.txt

FILE TYPE(T) TEXT(*.txt)

SAVE(S)
CANCEL
OPTION(O)

31001

FIG. 129

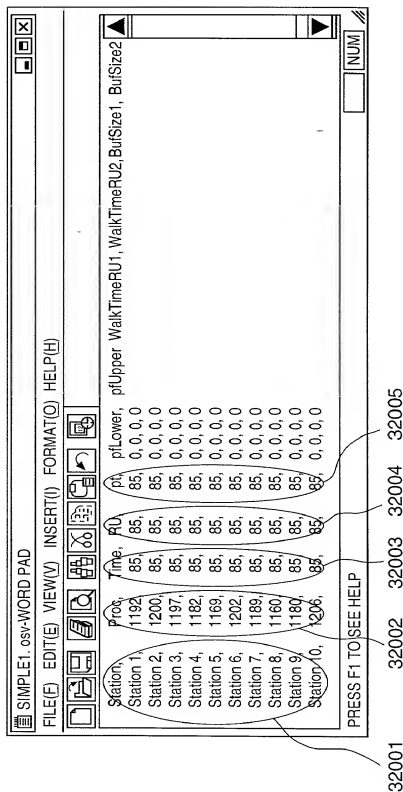


FIG. 131

34001	THE EXPECTED NUMBER OF PRODUCTS (U)	FIRST MONTH	SECOND MONTH	THIRD MONTH	FROM FOURTH MONTH
34002	EXPECTED NONADJUSTED RATIO (a) (THE NUMBER U2 OF DEFECTIVE PRODUCTS)	72 UNITS	120 UNITS	168 UNITS	240 UNITS
34003	EXPECTED NONADJUSTED RATIO (a) (THE NUMBER U2 OF DEFECTIVE PRODUCTS)	70% 31 UNITS	80% 30 UNITS	90% 191 UNITS	99.9% 0 UNITS
34004	NUMBER OF INITIAL PRODUCTS INVESTED INTO TOP OF ASSEMBLY LINE (U)	103 UNITS	150 UNITS	187 UNITS	240 UNITS
34005	EXPECTED STOP TIME (H) (LOSS RATIO (F%))	60 MIN (14%)	50 MIN (12%)	45 MIN (10%)	0 MIN (14%)
34006	EXPECTED COMPOSITION EFFICIENCY (E)	60% (50%--70%)	75% (70%--80%)	85% (80%--95%)	60% (95%--95%)
34007	EXPECTED PRODUCTION RATIO (E)	30%	50%	70%	100%

COMPOSITION CONDITIONS FOR FIRST MONTH (EXPECTED NONADJUSTED RATIO 70%, EXPECTED STOP TIME 60 MIN, AND EXPECTED COMPOSITION EFFICIENCY 50%)

FIG. 132

135/143

INPUT OF COMPOSITION DATA					
FILE(E) EDIT(E) TOOL(T) CHANGE WORK ORDER(M) OPTION(Q)					
TARGET MODEL	FILE NAME (COMPOSITION NAME)	REVISION NUMBER G			
PER(1000)	PERFORMANCE COOPERATION		01	<input type="checkbox"/>	

G.NO.	STANDARD NO.	WORK NAME	WF	MANUAL MANHOUR	MACHINE MANHOUR	PROVISIONAL SECTION COMPONENT	REMARKS
WORK STANDARD NO.							
SERIAL G NO.	WORK STANDARD NO.	WORK NAME	WF	MANUAL MANHOUR	MACHINE MANHOUR	COMPONENT NAME	NO.
1	1 9000000000000000000E	単位名称#1	579	579	0	セツト	1
2	2 9000000000000000000E	単位名称#2	54	54	0	セツト	2
3	3 9000000000000000000E	単位名称#3	10	10	0	セツト	3
4	4 9000000000000000000E	単位名称#4	50	50	0	セツト	4
5	5 9000000000000000000E	単位名称#1	63	63	0	ユヅ	5
6	6 9000000000000000000E	単位名称#2	30	30	0	ユヅ	6
7	7 9000000000000000000E	単位名称#3	196	196	0	ユヅ	7
8	8 9000000000000000000E	単位名称#4	35	35	0	ユヅ	8
9	9 9000000000000000000E	単位名称#5	162	162	0	ユヅ	9
27	27 9000000000000000000E	単位名称#23	55	55	0	ユヅ	27
28	28 9000000000000000000E	単位名称#24	86	86	0	ユヅ	28
29	29 9000000000000000000E	単位名称#25	147	147	0	ユヅ	29
30	30 9000000000000000000E	単位名称#26	52	52	0	ユヅ	30
31	31 9000000000000000000E	単位名称#27	55	55	0	ユヅ	31
32	32 9000000000000000000E	単位名称#28	203	203	0	ユヅ	32
33	33 9000000000000000000E	単位名称#29	66	66	0	ユヅ	33
34	34 9000000000000000000E	単位名称#30	36	36	0	ユヅ	34

TOTAL:		11903 (RU)
--------	--	------------

THE NUMBER OF WORKS IN COMPOSITION:		141
-------------------------------------	--	-----

TOTAL MANHOUR OUTSIDE WORKSHOP:		0 (RU)
---------------------------------	--	--------

TOTAL MANHOUR OUTSIDE COMPOSITION:		0 (RU)
------------------------------------	--	--------

EXECUTE COMPOSITION		[END]
---------------------	--	-------

INPUT DATA	
THE EXPECTED NUMBER OF PRODUCTS: 72 UNITS U1 THE NUMBER OF DEFECTIVE PRODUCTS: 31 UNITS U2 THE NUMBER OF INITIAL PRODUCT ASSEMBLY LINE TOP OF ASSEMBLY LINE: 103 UNITS	WORKING TIME: 450 MIN BREAK TIME: 15 MIN MORNING MEETING TIME: 1 MIN EXERCISE TIME: 5 MIN LINE STOP TIME: 60 MIN HI OTHERS: 0 MIN OPERATION TIME: 360 MIN EXPECTED COMPOSITION EFFICIENCY: 501 % RO CALCULATE

OUTPUT DATA	
STATION (ROUND DOWN) 6 St COMPOSITION EFFICIENCY 53% STATION (ROUND UP) 7 St COMPOSITION EFFICIENCY 147% THE NUMBER OF STATIONS 7 St Nst COMPOSITION EFFICIENCY 147% CALCULATION RESULT THE NUMBER OF STATIONS 6.6 St PITCH TIME (tp) 3592.52 RU	

FIG. 133

COMPOSITION CONDITIONS FOR SECOND MONTH (EXPECTED NONADJUSTED RATIO 80%, EXPECTED STOP TIME 50 MIN, AND EXPECTED COMPOSITION EFFICIENCY 70%)

[illegible]

COMPOSITION CONDITIONS FOR THIRD MONTH (EXPECTED NONADJUSTED RATIO 90%, EXPECTED STOP TIME 45 MIN., AND EXPECTED COMPOSITION EFFICIENCY 80%)

[illegible]

COMPOSITION CONDITIONS FOR FOURTH (EXPECTED NONADJUSTED RATIO 100%,
EXPECTED STOP TIME 0 MIN, AND EXPECTED COMPOSITION EFFICIENCY 95%)

FIG. 135

INPUT OF COMPOSITION DATA									
FILE(E) EDIT(E) TOOL(I) CHANGE WORK ORDER(M) OPTION(O)									
COMPOSITION DATA		REVISION		WORK		TOOL		NOTE	
TARGET MODEL	FILE NAME (COMPOSITION NAME)	NUMBER	G	COMPOSITION MODE	PRIORITY ORDER SCHEME				
PER1000	PERFORMANCE COOPERATION	01							
G.NO.	STANDARD NO.	WORK NAME	WF	MANUAL	MACHINE	MANHOUR	IN	SET	REMARKS
1	9000000000000000001E	WORK STANDARD NO. 579	579	0	0	0	0	0	
g	SERIAL WORK STANDARD NO.	WORK NAME	WF	MANUAL	MACHINE	MANHOUR	IN	SET	PREVIOUS
1	1 9000000000000000001E	単位名称s1	579	579	0	セツト	1	1	
2	2 9000000000000000002E	単位名称s2	54	54	0	セツト	2	1	
3	3 9000000000000000003E	単位名称s3	10	10	0	セツト	3	2	
4	4 9000000000000000004E	単位名称s4	50	50	0	セツト	4	3	
5	5 9000000000000000005E	単位名称u1	63	63	0	セツト	5	4	
6	6 9000000000000000006E	単位名称u2	30	30	0	セツト	6	4	
7	7 9000000000000000007E	単位名称u3	156	156	0	セツト	7	6	
8	8 9000000000000000008E	単位名称u4	35	35	0	セツト	8	4	
9	9 9000000000000000009E	単位名称u5	162	162	0	セツト	9	8	
27	27 90000000000000000027E	単位名称u23	55	55	0	セツト	27	22	
28	28 90000000000000000028E	単位名称u24	86	86	0	セツト	28	27	
29	29 90000000000000000029E	単位名称u25	147	147	0	セツト	29	4	
30	30 90000000000000000030E	単位名称u26	52	52	0	セツト	30	26	
31	31 90000000000000000031E	単位名称u27	55	55	0	セツト	31	30	
32	32 90000000000000000032E	単位名称u28	203	203	0	セツト	32	28	
33	33 90000000000000000033E	単位名称u29	66	66	0	セツト	33	31	
34	34 90000000000000000034E	単位名称u30	36	36	0	セツト	34	31	
TOTAL: 11903 (RU)						TOTAL MANHOUR OUTSIDE WORKSHOP: 0 (RU)			
THE NUMBER OF WORKS IN COMPOSITION: 141						TOTAL MANHOUR OUTSIDE COMPOSITION: 0 (RU)			

INPUT DATA		OUTPUT DATA	
THE EXPECTED NUMBER OF PRODUCTS	1240 UNITS	STATION (ROUND DOWN)	7 St
THE NUMBER OF DEFECTIVE PRODUCTS	0 UNITS	COMPOSITION EFFICIENCY	95 %
THE NUMBER OF INITIAL PRODUCTS INVESTED INTO TOP OF ASSEMBLY LINE	240 UNITS	STATION (ROUND UP)	8 St
WORKING TIME	450 MIN	COMPOSITION EFFICIENCY	80 %
BREAK TIME	15 MIN	THE NUMBER OF STATIONS	7 St
MORNING MEETING TIME	1 MIN	COMPOSITION EFFICIENCY	95 %
EXERCISE TIME	5 MIN	CALCULATION RESULT	
LINE STOP TIME	0 MIN	THE NUMBER OF STATIONS	7 St
OTHERS	0 MIN	PITCH TIME (tp)	1787.5 RU
OPERABLE TIME	429 MIN		
EXPECTED COMPOSITION EFFICIENCY	95 %		
[CALCULATE]			

FIG. 136

[illegible]

FIG. 137

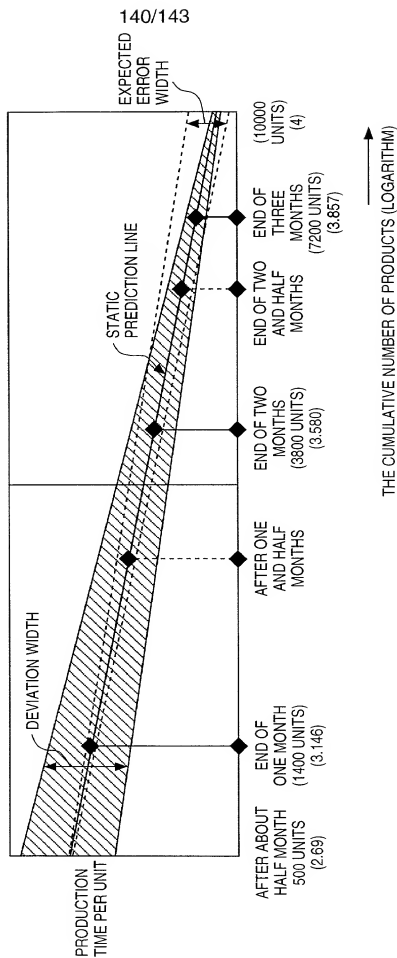


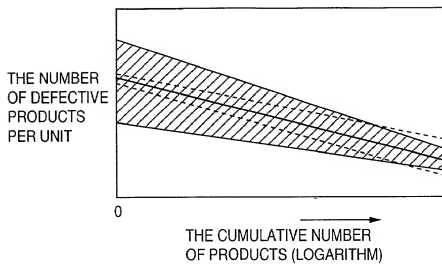
FIG. 138

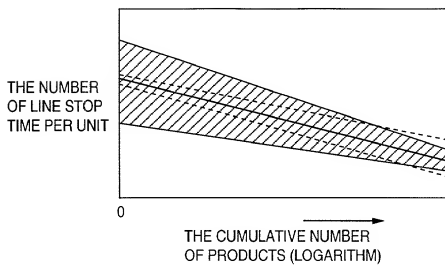
FIG. 139

FIG. 140